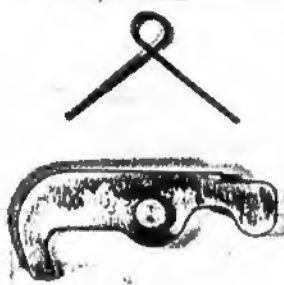
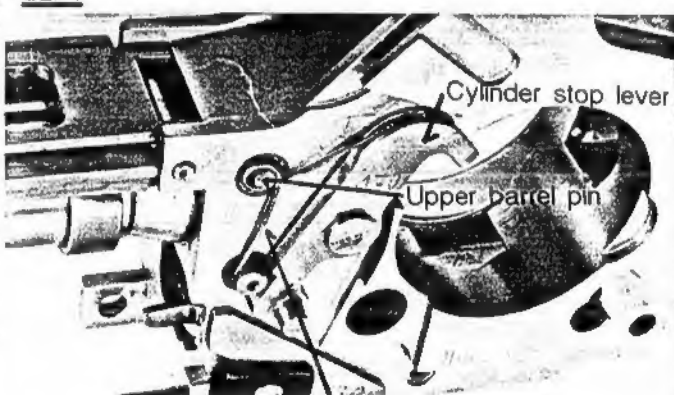
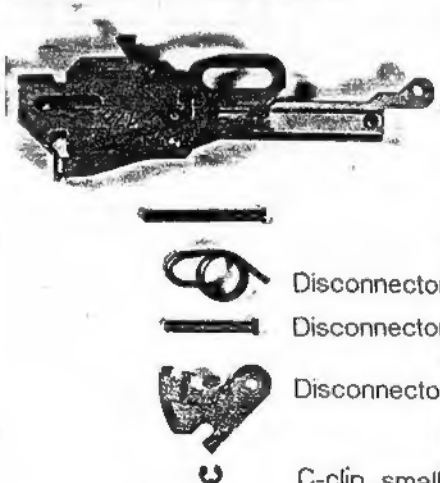


## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED:

- o BUFFER ASSEMBLY
- o FIXTURE
- o TWEEZERS
- o NOTCHED SCREWDRIVER
- o DRIFT PUNCH, Ø 2.4 mm
- o BARREL VICE BLOCKS
- o CONTROL DISK WRENCH
- o HAMMER, 100 g
- o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><b>CYLINDER STOP LEVER</b></p> <div style="display: flex; align-items: center;">  <div style="margin-left: 10px;"> <p>Cylinder stop lever spring (2000.20)</p> <p>Cylinder stop lever (2007)</p> </div> </div> <p><u>LEFT</u></p>  <p>STEP 1 + 2</p>	<ol style="list-style-type: none"> <li>1. Place the loop of the cylinder stop lever spring over the upper barrel pin by squeezing the ends together.</li> <li>2. Position one arm of the spring against the front side of the lower barrel pin and the other arm within the groove located on the back of the cylinder stop lever.</li> </ol>
<p><b>SLIDE AND DISCONNECTOR</b></p> <div style="display: flex; align-items: center;">  <div style="margin-left: 10px;"> <p>Slide, cpl. (2050)</p> <p>Slide axle (2050.1)</p> <p>Disconnector spring (2000.23)</p> <p>Disconnector axle (2000.22)</p> <p>Disconnector (2000.24)</p> <p>C-clip, small (2000.21)</p> </div> </div>	

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

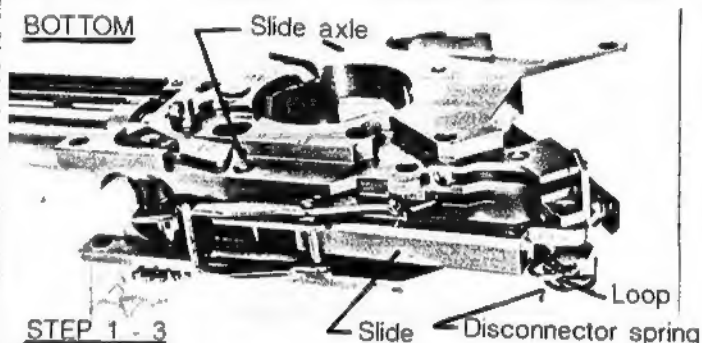
TOOLS REQUIRED: o BUFFER ASSEMBLY  
o TWEEZERS  
o NOTCHED SCREWDRIVER  
o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS  
o CONTROL DISK WRENCH  
o HAMMER, 100 g  
o FLAT HEAD SCREWDRIVER, LARGE

### ACTION VIEW

### REMARKS

BOTTOM

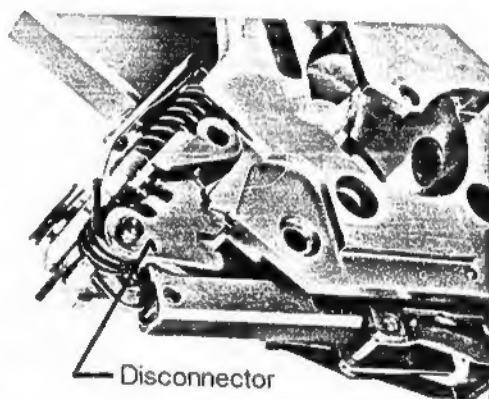


1. Place the slide, CPL. Within the space provided in the bottom of the breech cylinder housing.

2. Install the slide axle from right to left to secure the front of the slide.

3. Place the coils of the disconnecter spring around the bushing with the loop facing up.

RIGHT



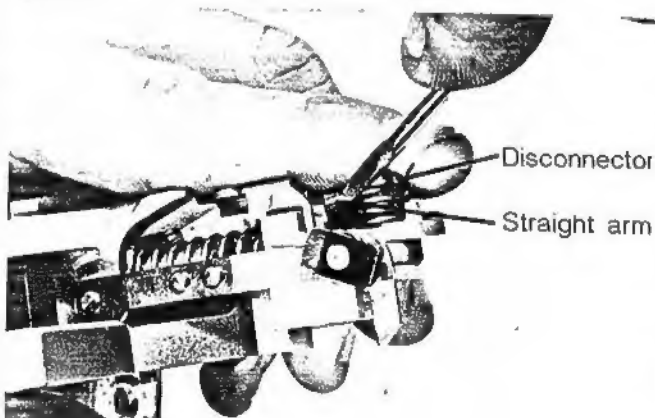
4. Position the disconnecter within the slot of the breech cylinder housing as pictured.

5. Insert the axle from right to left through the disconnecter, disconnecter spring, bushing and finally the slide.

STEP 4 + 5

The head of the axle should rest against the disconnecter.

BACK



6. Using the notched screw driver, hook the straight arm of the disconnecter spring on the tab of the disconnecter to place the disconnecter under spring tension.

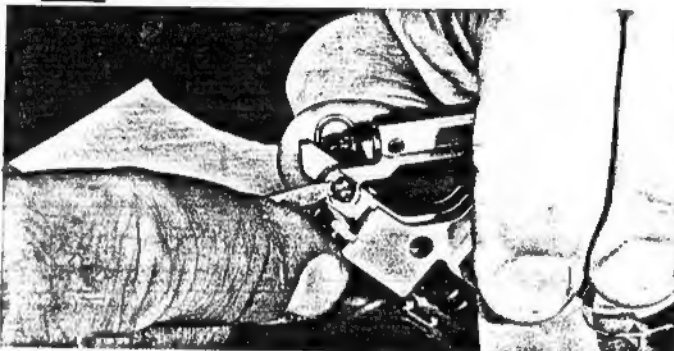
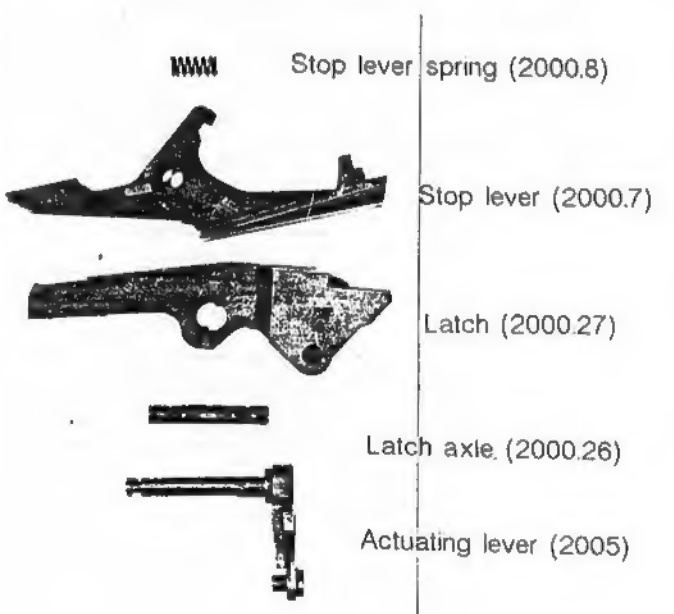
STEP 6

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED:

- o BUFFER ASSEMBLY
- o FIXTURE
- o TWEEZERS
- o NOTCHED SCREWDRIVER
- o DRIFT PUNCH, Ø 2.4 mm
- o BARREL VICE BLOCKS
- o CONTROL DISK WRENCH
- o HAMMER, 100 g
- o FLAT HEAD SCREWDRIVER, LARGE

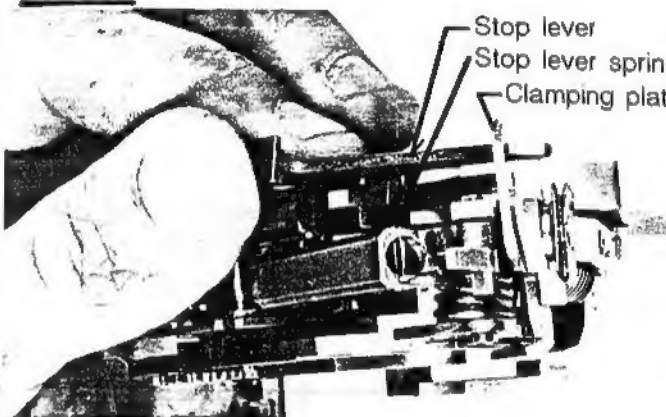
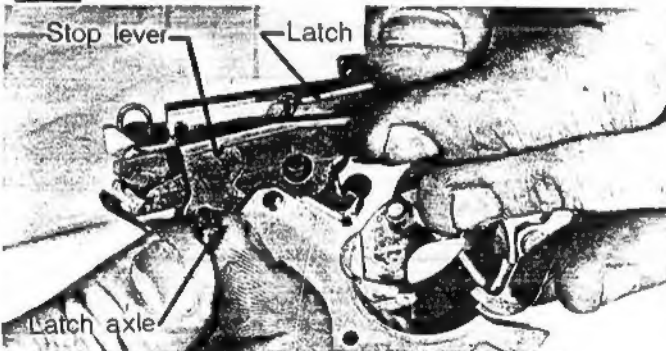
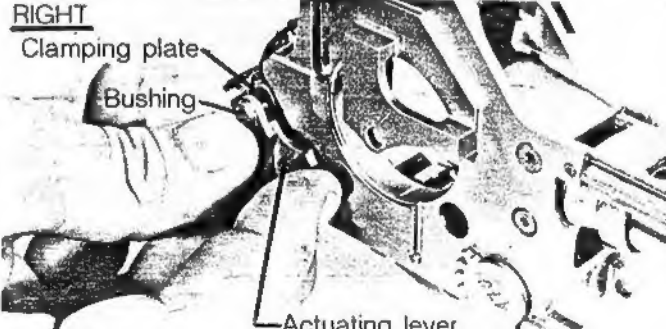
ACTION VIEW	REMARKS
<p><u>LEFT</u></p>  <p><u>STEP 7</u></p>	<p>7. With your left thumb, push the disconnecter axle against the disconnecter spring to expose the notch located on the end of the axle.</p> <p>Holding it in that position, attach the small C-clip.</p>
<p>ACTUATING LEVER, STOP LEVER AND LATCH</p> 	

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
o FIXTURE  
o TWEEZERS  
o NOTCHED SCREWDRIVER  
o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS  
o CONTROL DISK WRENCH  
o HAMMER, 100 g  
o FLAT HEAD SCREWDRIVER,  
LARGE

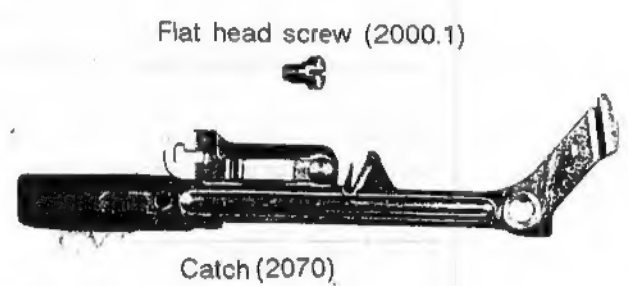
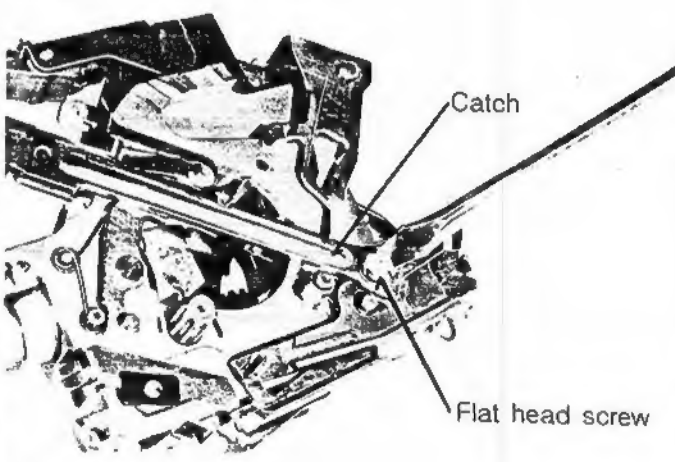
ACTION VIEW	REMARKS
<p><u>BOTTOM</u></p>  <p>STEP 1 + 2</p>	<ol style="list-style-type: none"> <li>1. Place the stop lever spring into the hole located to the right of the slide.</li> <li>2. Place the rear end of the stop lever under the clamping plate with the tab on the stop lever over the stop lever spring.</li> </ol> <p>Push down and hold the stop lever in place against the spring tension of the stop lever spring.</p>
<p><u>LEFT</u></p>  <p>STEP 3 + 4</p>	<p>CAUTION: STOP LEVER SPRING IS EASILY LOST!</p> <ol style="list-style-type: none"> <li>3. Slide the latch over top of the stop lever from rear to front.</li> <li>4. Install the latch axle into the hole provided on the rear of the latch.</li> </ol>
<p><u>RIGHT</u></p>  <p>STEP 5 + 6</p>	<ol style="list-style-type: none"> <li>5. From the right side, insert the axle of the actuating lever into the hole and through the breech cylinder housing and the stop lever.</li> <li>6. Turn the actuating lever so that the round bushing engages with the hole on the clamping plate.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY ,  
 o FIXTURE  
 o TWEEZERS  
 o NOTCHED SCREWDRIVER  
 o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS  
 o CONTROL DISK WRENCH  
 o HAMMER, 100 g  
 o FLAT HEAD SCREWDRIVER, LARGE

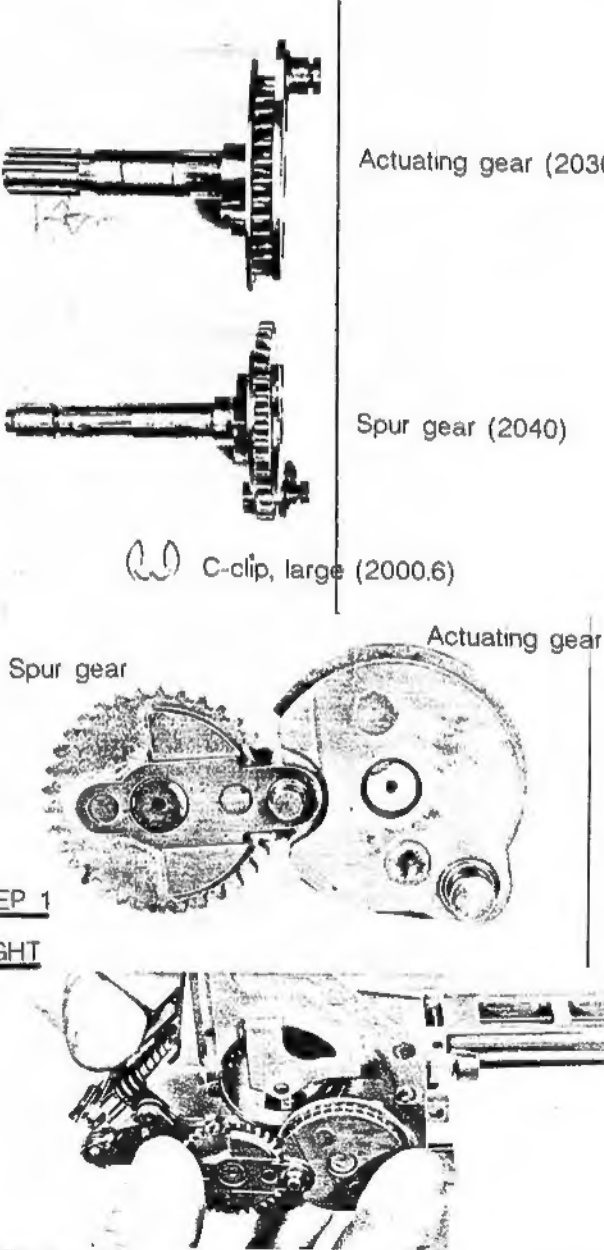
ACTION VIEW	REMARKS
<p data-bbox="156 666 235 698"><b>CATCH</b></p> <div data-bbox="203 720 831 1004">  <p data-bbox="344 731 674 775">Flat head screw (2000.1)</p> <p data-bbox="376 960 533 1004">Catch (2070)</p> </div> <p data-bbox="156 1255 235 1288"><b>LEFT</b></p> <div data-bbox="156 1310 831 1769">  <p data-bbox="595 1386 674 1430">Catch</p> <p data-bbox="595 1692 799 1736">Flat head screw</p> </div> <p data-bbox="156 1769 329 1812"><b>STEP 1 + 2</b></p>	<ol style="list-style-type: none"> <li data-bbox="862 1124 1401 1354">1. With the top end of the catch pointing to a 10 o'clock position (closed position), line up the hole in the bottom of the catch with the hole provided in the breech cylinder housing.</li> <li data-bbox="862 1375 1401 1485">2. Install the flat head screw and tighten using the large flat head screwdriver.</li> <li data-bbox="862 1506 1401 1747">3. Pull the catch release lever towards you to unlock the catch and push the catch counter clockwise approx. 450 ° until it snaps into unlocked position.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED:

- o BUFFER ASSEMBLY FIXTURE
- o TWEEZERS
- o NOTCHED SCREWDRIVER
- o DRIFT PUNCH, Ø 2.4 mm
- o BARREL VICE BLOCKS
- o CONTROL DISK WRENCH
- o HAMMER, 100 g
- o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p>SPUR AND ACTUATING GEAR</p>  <p>Actuating gear (2030)</p> <p>Spur gear (2040)</p> <p>C-clip, large (2000.6)</p> <p>Spur gear</p> <p>Actuating gear</p> <p><u>STEP 1</u> <u>RIGHT</u></p> <p><u>STEP 2 + 3</u></p>	<ol style="list-style-type: none"> <li>1. Join the spur gear and actuator gear as pictured.</li> <li>2. From the right side, slide the axles of the spur and actuating gears into the holes below the opening for the breech cylinder.</li> <li>3. While pushing against the spur and actuator gears, depress the forward end of the stop lever and the two gears should snap into place.</li> </ol> <p>NOTE: YOU MUST PUSH VERY HARD ON THE STOP LEVER TO <u>FULLY</u> SEAT THE SPUR AND ACTUATOR GEARS.</p>

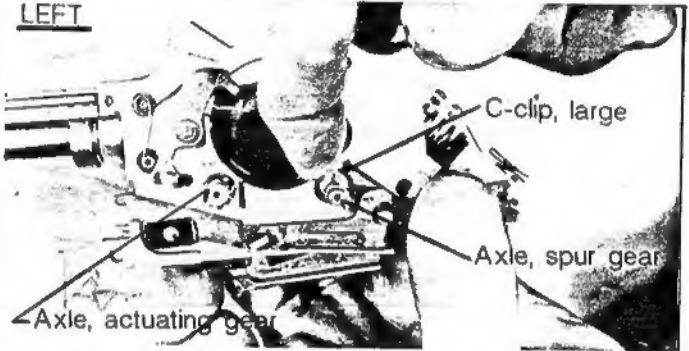
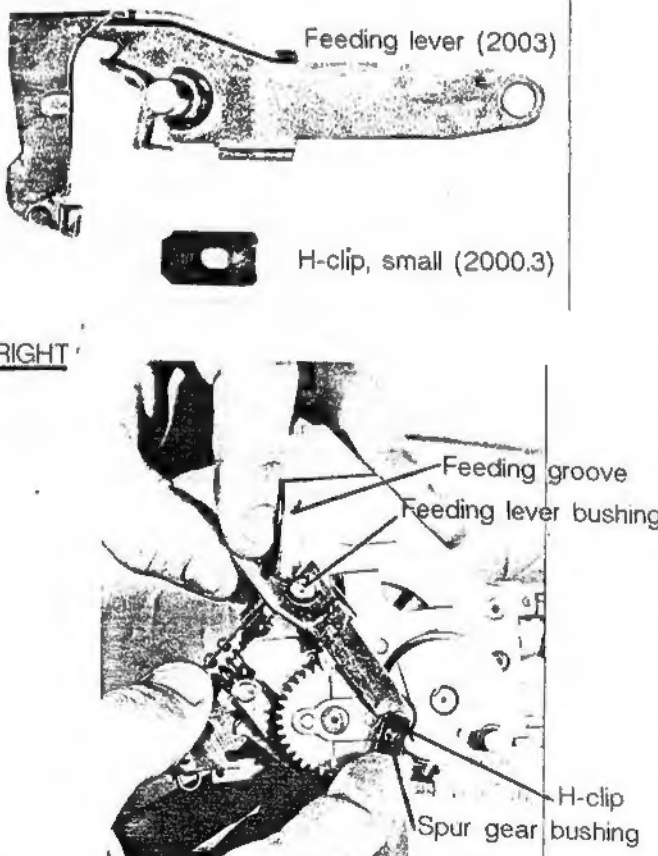


## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
o FIXTURE  
o TWEEZERS  
o NOTCHED SCREWDRIVER  
o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS  
o CONTROL DISK WRENCH  
o HAMMER, 100 g  
o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><u>LEFT</u></p>  <p><u>STEP 4</u></p>	<p>4. Attach the large C-clip to the axle of the spur gear on the left side of the breech cylinder housing.</p>
<p><u>FEEDING LEVER</u></p>  <p><u>RIGHT</u></p> <p><u>STEP 1 - 4</u></p>	<ol style="list-style-type: none"> <li>1. Align the bushing on the feeding lever with the opening of the feeding groove.</li> <li>2. Slide the feeding lever into the feeding groove.</li> <li>3. Place the bottom end of the feeding lever over the bushing of the spur gear.</li> <li>4. Attach a small H-clip to the end of the bushing of the spur gear to secure the end of the feeding lever.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED:

- o BUFFER ASSEMBLY
- o FIXTURE
- o TWEEZERS
- o NOTCHED SCREWDRIVER
- o DRIFT PUNCH, Ø 2.4 mm
- o BARREL VICE BLOCKS
- o CONTROL DISK WRENCH
- o HAMMER, 100 g
- o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><b>GUIDE HOUSING AND EJECTOR LEVER</b></p> <p>Ejector (2101.2)</p> <p>Ejector lever (2100.7)</p> <p>Guide housing (2100)</p> <p>Roll pin (2000.9)</p> <p>Spring, ejector lever (2100.6)</p> <p>Axle, ejector lever (2100.5)</p> <p>H-clip, small (2100.4)</p> <p><u>LEFT</u></p> <p>Ejector lever</p> <p>Guide housing</p> <p><u>STEP 1</u></p>	<p>1. Slide the hook end of the ejector lever through the guide housing.</p>

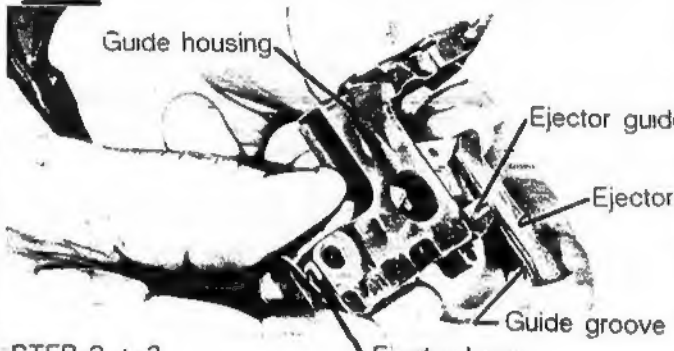
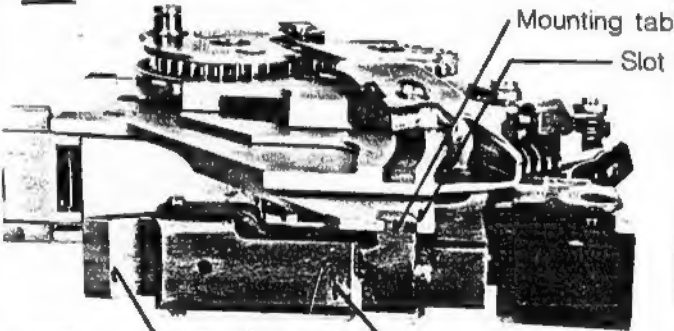
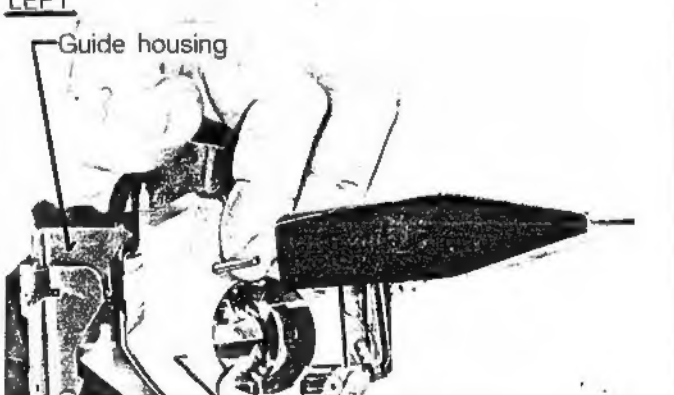


## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
 ○ FIXTURE  
 ○ TWEEZERS  
 ○ NOTCHED SCREWDRIVER  
 ○ DRIFT PUNCH, Ø 2.4 mm

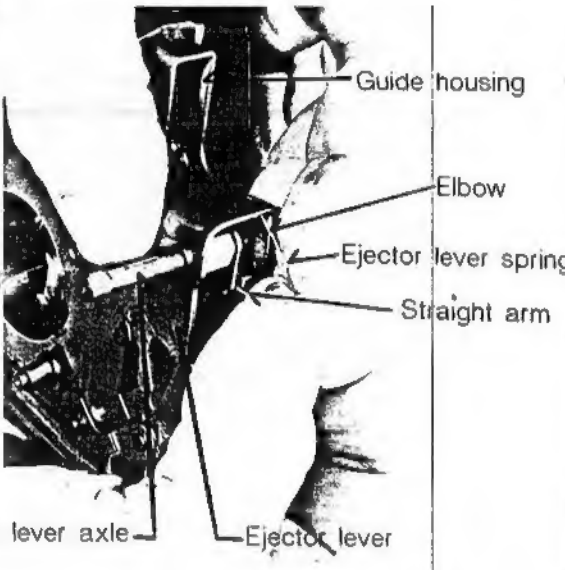
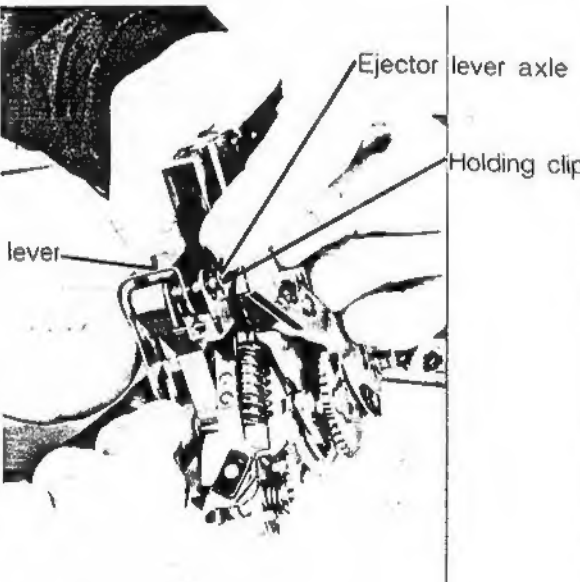
○ BARREL VICE BLOCKS  
 ○ CONTROL DISK WRENCH  
 ○ HAMMER, 100 g  
 ○ FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><b>RIGHT</b></p>  <p><b>STEP 2 + 3</b></p>	<p>2. Attach the ejector to the ejector lever by engaging the hook of the ejector lever on the solid pin located in the top of the ejector.</p> <p>NOTE: BE SURE THAT THE GUIDE GROOVE IN THE EJECTOR FACES REARWARD.</p> <p>3. Slide the end of the ejector guide into the top of the back of the ejector.</p>
<p><b>TOP</b></p>  <p><b>STEP 4</b></p>	<p>4. Place the entire assembly (guide housing with ejector lever and ejector) down on top of the breech cylinder housing with the magazine catch pointing forward and the mounting tab of the guide housing engaged in the slot provided on the breech cylinder housing.</p>
<p><b>LEFT</b></p>  <p><b>STEP 5</b></p>	<p>5. Install the roll pin into the breech cylinder housing from left to right to secure the guide housing to the breech cylinder housing.</p> <p>NOTE: CENTER THE ROLL PIN IN THE BREECH CYLINDER. ENSURE THAT THE ROLL PIN DOES NOT BLOCK THE MOVEMENT OF THE FEEDING LEVER THROUGH THE FEEDING GROOVE.</p>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
 o TWEEZERS  
 o NOTCHED SCREWDRIVER  
 o DRIFT PUNCH, Ø 2.4 mm  
 o BARREL VICE BLOCKS  
 o CONTROL DISK WRENCH  
 o HAMMER, 100 g  
 o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><u>REAR</u></p>  <p>Diagram showing the rear view of the breech assembly. Labels include: Guide housing, Elbow, Ejector lever spring, Straight arm, Ejector lever axle, and Ejector lever.</p>	<p>6. Partially insert the ejector lever axle from left to right into the guide housing and breech cylinder housing.</p> <p>7. Install the ejector lever spring between the left side of the guide housing and the right side of the ejector lever.</p> <p><u>MAKE SURE THAT THE LONG ARM WITH ELBOW RESTS ON THE UNDERSIDE OF THE EJECTOR LEVER AND THE SHORT, STRAIGHT ARM IS CAUGHT BEHIND THE ROLL PIN.</u></p>
<p><u>STEP 6 - 7</u></p> <p><u>REAR</u></p>  <p>Diagram showing the rear view of the breech assembly. Labels include: Ejector lever axle and Holding clip.</p>	<p>8. Push in on the coil of the ejector lever spring until the ejector lever axle can be passed through it.</p> <p>9. Push against the head of the ejector lever axle and attach a small H-clip to the right end to secure it.</p>
<p><u>STEP 7 - 9</u></p>	

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
FIXTURE

o TWEEZERS

o NOTCHED SCREWDRIVER

o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS

o CONTROL DISK WRENCH

o HAMMER, 100 g

o FLAT HEAD SCREWDRIVER,  
LARGE

ACTION VIEW	REMARKS
<p><b>CONTROL LEVER AND SPRING</b></p> <p>Control lever spring (2000.5)</p> <p>Control lever (2004)</p> <p>H-clip, small (2000.4)</p> <p><b>RIGHT</b></p> <p>Tab</p> <p>Bushing</p> <p>Control lever spring</p> <p><b>STEP 1</b></p> <p><b>LEFT</b></p> <p>Ejector</p> <p>H clip, small</p> <p>Ejector lever</p> <p>Actuator lever axle</p> <p>Free end of control lever spring</p> <p>Spur gear axle</p> <p><b>STEP 2 + 3</b></p>	<p>1. Place the control lever spring around the bushing of the control lever with one arm of the spring resting on top of the tab.</p> <p>2. Hook the free end of the control lever spring under the end of the actuator lever axle</p> <p>- as you -</p> <p>o Slide the control lever bushing over the spur gear axle</p> <p>- and -</p> <p>o Insert the bushing on the rear end of the control lever through the opening on the feeding lever. (NOTE: You may need to raise the ejector out of the opening for the breech cylinder in order to fit the bushing of the control lever into the opening of the ejector lever.)</p>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

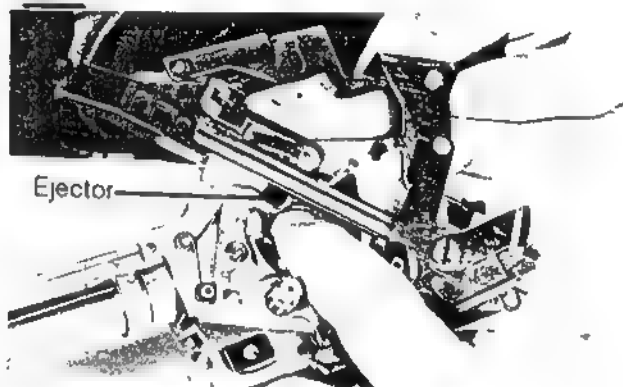
TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
 ○ FIXTURE  
 ○ TWEEZERS  
 ○ NOTCHED SCREWDRIVER  
 ○ DRIFT PUNCH, Ø 2.4 mm

○ BARREL VICE BLOCKS  
 ○ CONTROL DISK WRENCH  
 ○ HAMMER, 100 g  
 ○ FLAT HEAD SCREWDRIVER,  
 LARGE

### ACTION VIEW

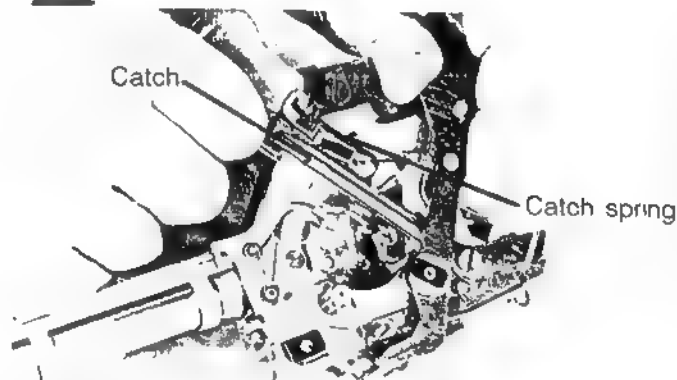
### REMARKS

LEFT

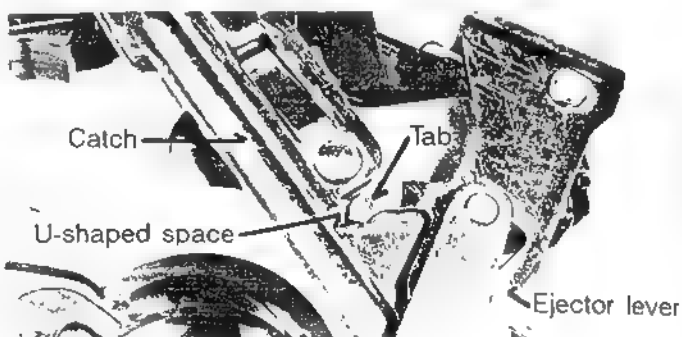


STEP 4

LEFT



STEP 5



STEP 5 (NOTE)

3. Attach a small H-clip to the end of the spur gear axle to secure the control lever.
4. Reach into the opening for the breech cylinder and push the ejector all the way up and out of the opening and hold it there.
5. Pull the catch spring up and rotate the catch clockwise to its open position.

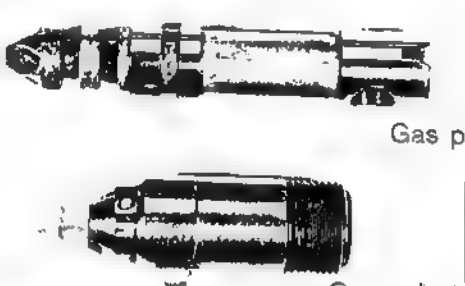
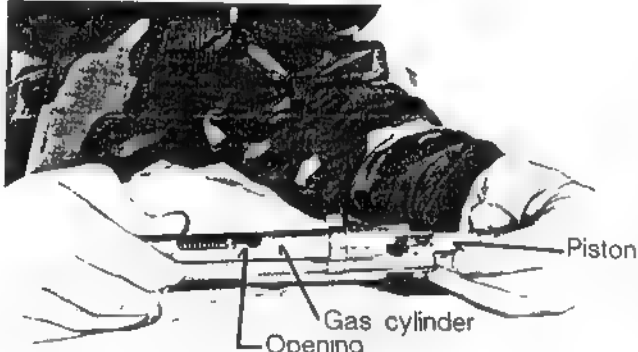
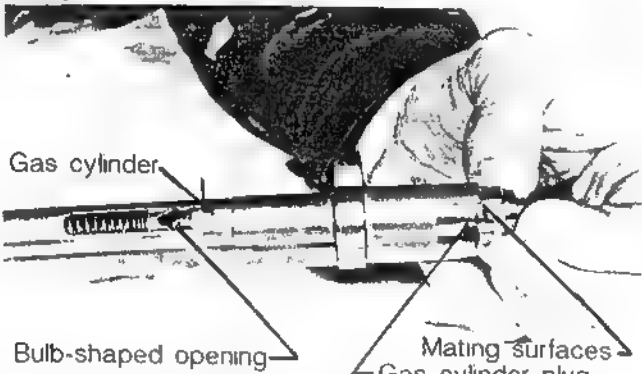
NOTE: ENSURE THAT THE TAB OF THE EJECTOR LEVER FITS WITHIN THE U-SHAPED SPACE ALONG THE REAR EDGE OF THE CATCH.

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
o FIXTURE  
o TWEEZERS  
o NOTCHED SCREWDRIVER  
o DRIFT PUNCH, # 2.4 mm

o BARREL VICE BLOCKS  
o CONTROL DISK WRENCH  
o HAMMER, 100 g  
o FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><b>GAS SYSTEM</b></p>  <p>Gas piston (2200.5)</p> <p>Gas cylinder plug (2202)</p>	
<p><b>RIGHT</b></p>  <p>Piston</p> <p>Gas cylinder</p> <p>Opening</p>	<p>1. Install the gas piston into the gas cylinder so that the pointed end of the piston is pointing forward <u>and</u> the bulb-shaped opening on the rear of the piston faces to the right and is visible through the opening in the cylinder.</p>
<p><b>STEP 1</b></p> <p><b>RIGHT</b></p>  <p>Gas cylinder</p> <p>Bulb-shaped opening</p> <p>Mating surfaces</p> <p>Gas cylinder plug</p>	<p>2. Install the gas cylinder plug into the open end of the gas cylinder. Ensure that the mating surfaces of the plug and the end of the cylinder align.</p> <p>3. Using the wrench incorporated into the front of the connecting rod, turn the screw of the gas cylinder plug in a clockwise motion tighten it to the cylinder.</p>
<p><b>STEP 1 + 2</b></p>	



## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
FIXTURE

o TWEEZERS

o NOTCHED SCREWDRIVER

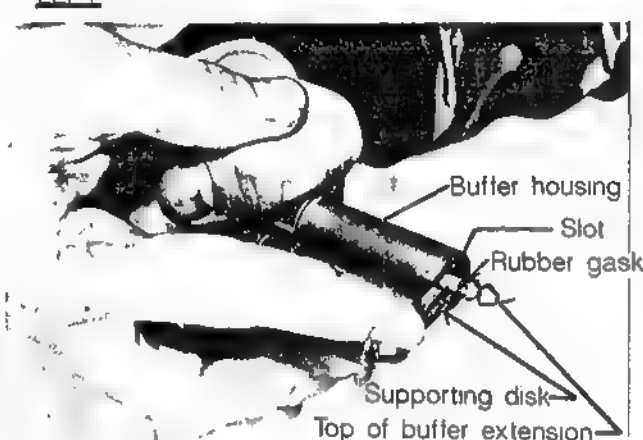
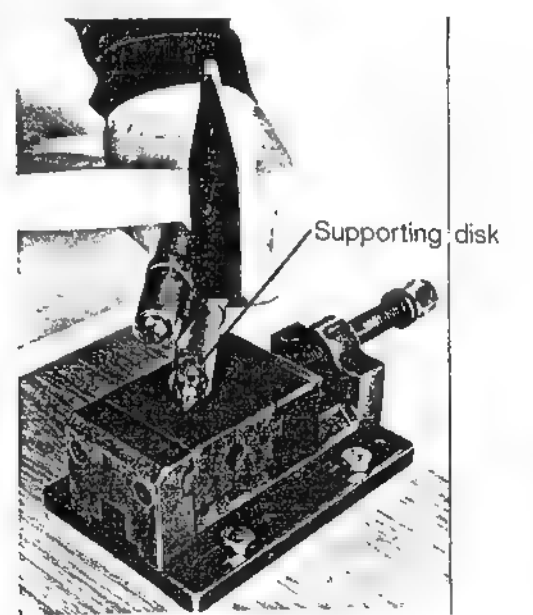
o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS

o CONTROL DISK WRENCH

o HAMMER, 100 g

o FLAT HEAD SCREWDRIVER,  
LARGE

ACTION VIEW	REMARKS
<p><u>LEFT</u></p>  <p><u>STEP 5</u></p>	<p>5. When the tip of the buffer extension exits the front of the buffer housing, insert the supporting disk into the slot below the rubber gasket.</p> <p>6. Seat the supporting disk by tapping the flat side with a hammer.</p> <p>NOTE: THE SUPPORTING DISK MUST BE SEATED IN THE U-SHAPED SPACE PROVIDED ON THE END OF THE BUFFER HOUSING.</p>
<p><u>LEFT</u></p>  <p><u>STEP 6</u></p>	

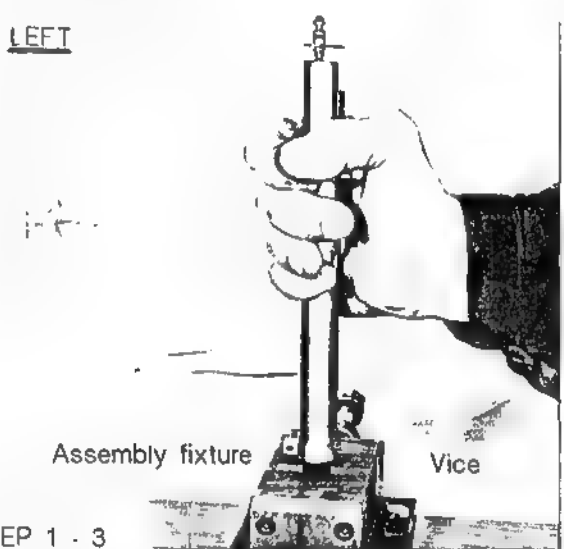
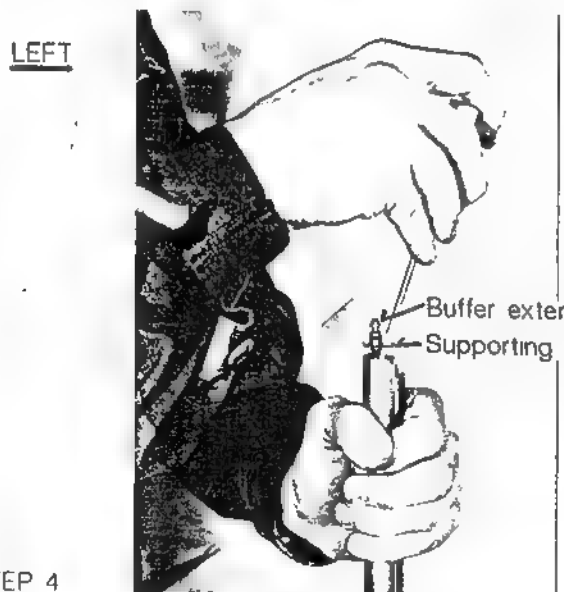


## ARMORERS DISASSEMBLY

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
FIXTURE  
o TWEEZERS  
o NOTCHED SCREWDRIVER  
o DRIFT PUNCH, Ø 2.4 mm

o BARREL VICE BLOCKS  
o CONTROL DISK WRENCH  
o HAMMER, 100 g  
o FLAT HEAD SCREWDRIVER,  
LARGE

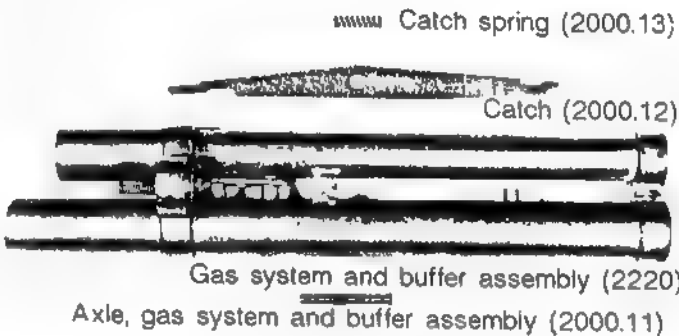
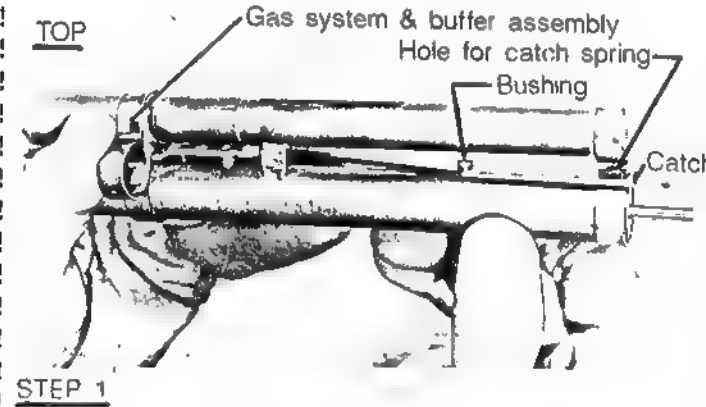
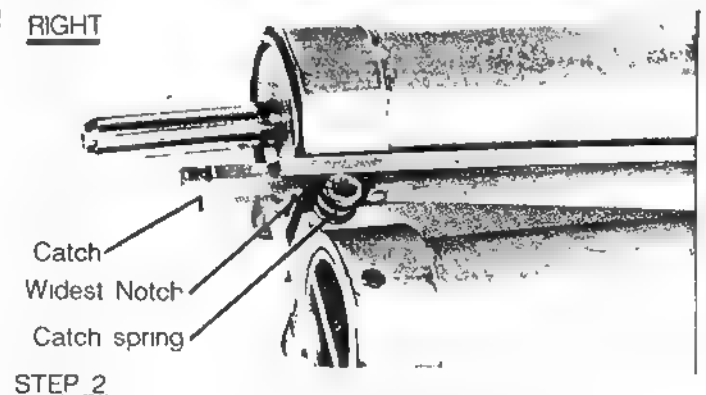
ACTION VIEW	REMARKS
<p>BUFFER MECHANISM</p> <p><u>LEFT</u></p>  <p>Assembly fixture      Vice</p> <p><u>STEP 1 - 3</u></p>	<p><b>WARNING: BEWARE OF THE SPRING TENSION STORED WITHIN THE COMPRESSED BUFFER SPRING. USE THE ASSEMBLY FIXTURE MOUNTED IN A VICE TO REMOVE THE SUPPORTING DISK.</b></p> <ol style="list-style-type: none"> <li>1. Mount the buffer assembly fixture in a vice leaving one half protruding.</li> <li>2. Insert the buffer rod into the assembly fixture with the tip of the buffer extension facing up.</li> <li>3. Push the buffer housing down against the assembly fixture to release the tension on the supporting disk <u>and hold it in that position.</u></li> </ol>
<p><u>LEFT</u></p>  <p>Buffer extension Supporting disk</p> <p><u>STEP 4</u></p>	<ol style="list-style-type: none"> <li>4. With your free hand, insert the small flat head screw driver into the slot of the supporting disk and gently press the supporting disk off of the buffer extension.</li> <li>5. Slowly and carefully allow the buffer housing to rise as you release the spring tension stored in the buffer spring.</li> <li>6. Remove the buffer and buffer spring from the buffer housing.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
 ○ FIXTURE  
 ○ TWEEZERS  
 ○ NOTCHED SCREWDRIVER  
 ○ DRIFT PUNCH, Ø 2.4 mm

○ BARREL VICE BLOCKS  
 ○ CONTROL DISK WRENCH  
 ○ HAMMER, 100 g  
 ○ FLAT HEAD SCREWDRIVER, LARGE

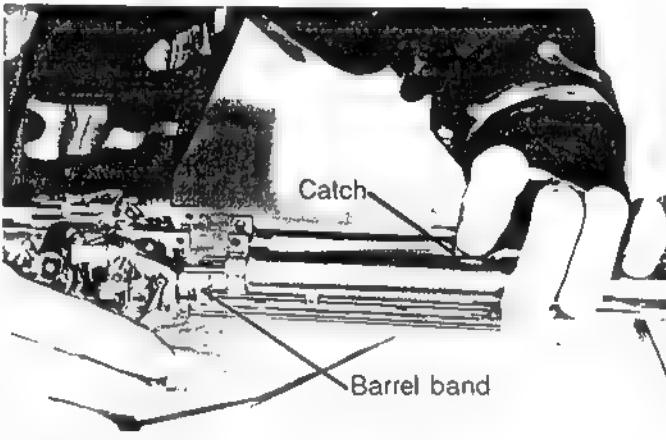
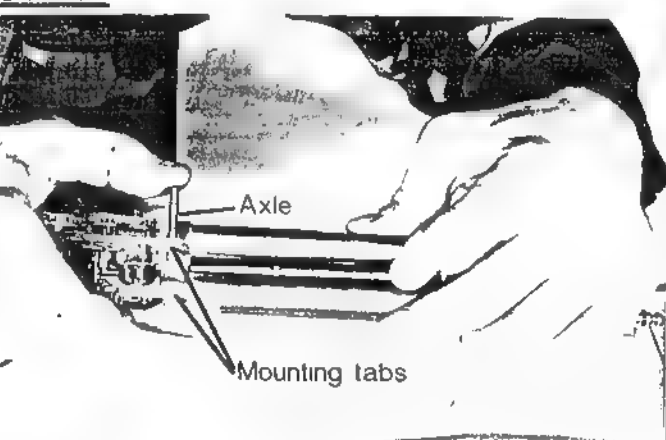
ACTION VIEW	REMARKS
<p data-bbox="189 668 686 701">GAS SYSTEM AND BUFFER ASSEMBLY</p> <div data-bbox="216 744 895 1078">  <p data-bbox="545 744 895 777">Catch spring (2000.13)</p> <p data-bbox="696 832 895 864">Catch (2000.12)</p> <p data-bbox="404 995 895 1028">Gas system and buffer assembly (2220)</p> <p data-bbox="283 1039 895 1072">Axle, gas system and buffer assembly (2000.11)</p> </div> <div data-bbox="189 1116 895 1520"> <p data-bbox="189 1126 275 1159"><u>TOP</u></p>  <p data-bbox="189 1487 291 1520"><u>STEP 1</u></p> </div> <div data-bbox="189 1563 895 1956"> <p data-bbox="189 1574 291 1607"><u>RIGHT</u></p>  <p data-bbox="189 1924 291 1956"><u>STEP 2</u></p> </div>	<div data-bbox="911 1116 1448 1410"> <ol style="list-style-type: none"> <li data-bbox="911 1116 1448 1247">1. Insert the catch spring into the hole in the rear of the gas system and buffer assembly.</li> <li data-bbox="911 1279 1448 1410">2. Place the hole located in the middle of the catch over the bushing on the inside of the buffer housing.</li> </ol> </div> <p data-bbox="911 1443 1448 1574">NOTE: THE WIDEST OF THE TWO U-SHAPED NOTCHES ON THE CATCH SHOULD FIT DIRECTLY OVER THE CATCH SPRING.</p> <ol style="list-style-type: none"> <li data-bbox="911 1607 1448 1705">3. Push the front end of the catch up against the catch spring and hold it there.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
 ○ FIXTURE  
 ○ TWEEZERS  
 ○ NOTCHED SCREWDRIVER  
 ○ DRIFT PUNCH, Ø 2.4 mm

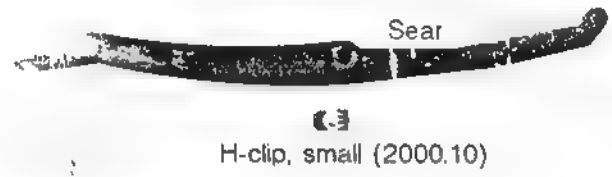
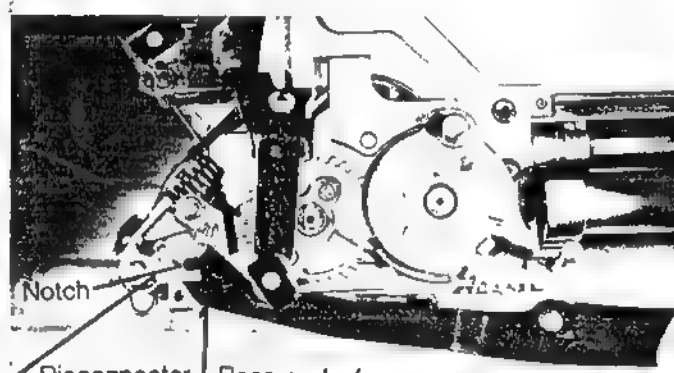
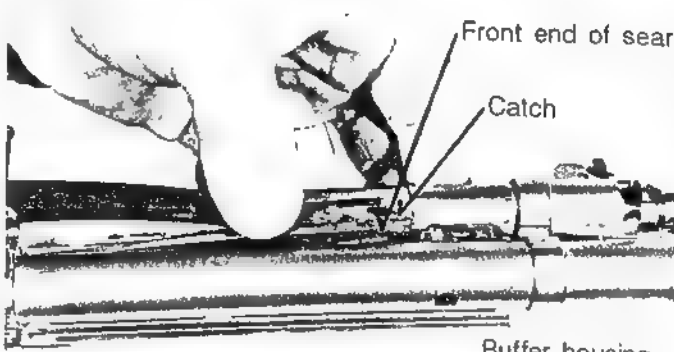
○ BARREL VICE BLOCKS  
 ○ CONTROL DISK WRENCH  
 ○ HAMMER, 100 g  
 ○ FLAT HEAD SCREWDRIVER, LARGE

ACTION VIEW	REMARKS
<p><u>LEFT</u></p>  <p>STEP 4</p>	<p>4. Slide the barrel through the barrel band on the front of the gas system and buffer assembly.</p> <p>5. Still holding the catch, pull back on the entire gas system and buffer assembly until the holes in the mounting tabs located on both the breech cylinder housing and the gas system and buffer assembly align.</p> <p>6. Hold everything in that position and insert the axle from right to left through only the right side mounting holes.</p>
<p><u>BOTTOM</u></p>  <p>STEP 5</p>	<p>NOTE: DO NOT PUSH THE AXLE ALL THE WAY THROUGH YET!</p>

# ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: o BUFFER ASSEMBLY  
 o FIXTURE  
 o TWEEZERS  
 o NOTCHED SCREWDRIVER  
 o DRIFT PUNCH, Ø 2.4 mm  
 o BARREL VICE BLOCKS  
 o CONTROL DISK WRENCH  
 o HAMMER, 100 g  
 o FLAT HEAD SCREWDRIVER, LARGE


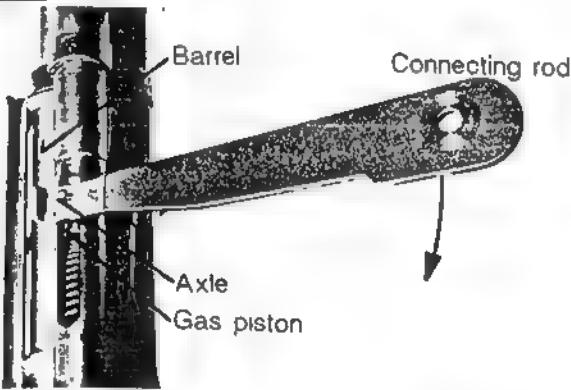
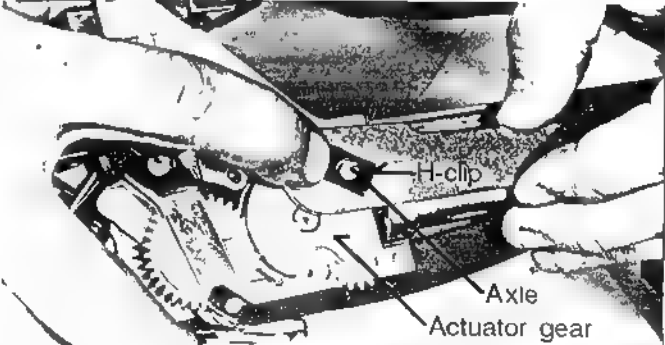
ACTION VIEW	REMARKS
<p>SEAR</p>  <p>H-clip, small (2000.10)</p>	
<p><u>RIGHT</u></p>  <p>Notch Disconnector Rear end of sear</p> <p><u>STEP 1</u></p>	<ol style="list-style-type: none"> <li>1. Engage the solid bushing on the rear of the sear with the U-shaped notch on the disconnector.</li> <li>2. Push (bend) the front end of the sear from left to right until the roll pin located there can engage in the U-shaped notch on the top of the catch.</li> </ol>
<p><u>LEFT</u></p>  <p>Front end of sear Catch Buffer housing</p> <p><u>STEP 2</u></p>	<ol style="list-style-type: none"> <li>3. Push the gas system and buffer assembly axle through the sear and through the left side mounting tabs of the breech cylinder housing.</li> <li>4. Secure the axle by attaching a small H-clip to the left end of the axle.</li> </ol>

## ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
FIXTURE  
○ TWEEZERS  
○ NOTCHED SCREWDRIVER  
○ DRIFT PUNCH, Ø 2.4 mm

○ BARREL VICE BLOCKS  
○ CONTROL DISK WRENCH  
○ HAMMER, 100 g  
○ FLAT HEAD SCREWDRIVER,  
LARGE

ACTION VIEW	REMARKS
<p data-bbox="174 663 409 694">CONNECTING ROD</p>  <p data-bbox="398 891 675 921">Connecting rod (2002)</p> <p data-bbox="487 941 827 984">H-clip, large (2000.2)</p> <p data-bbox="216 1043 288 1074">RIGHT</p>  <p data-bbox="225 1472 319 1502">STEP 1</p> <p data-bbox="216 1524 288 1555">RIGHT</p>  <p data-bbox="194 1924 288 1954">STEP 2</p>	<ol style="list-style-type: none"> <li data-bbox="900 1087 1397 1247">1. Holding the connecting rod perpendicular to the barrel, insert the axle into the bulb-shaped hole in the gas piston.</li> <li data-bbox="900 1279 1397 1439">2. Turn the connecting rod in a counter clockwise direction until it makes contact with the bushing on the actuator gear.</li> <li data-bbox="900 1472 1430 1596">3. Lift upwards on the connecting rod and place the axle on the actuator gear through the hole of the connecting rod.</li> <li data-bbox="900 1629 1397 1727">4. Secure the connecting rod in place by attaching a large H-clip.</li> </ol>

# ARMORERS REASSEMBLY (CONT)

ITEM(S): BARREL & BREECH ASSEMBLY (2000)

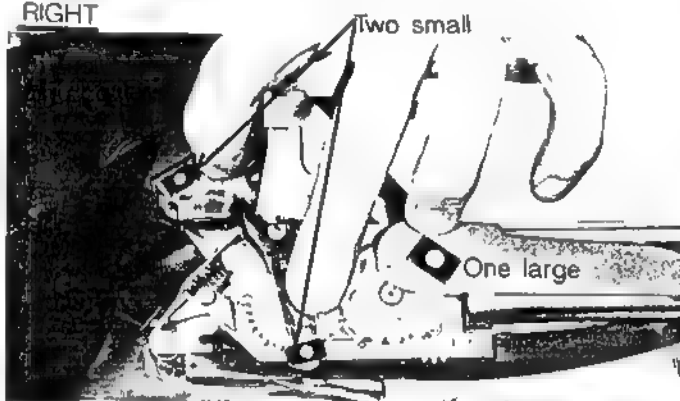
TOOLS REQUIRED: ○ BUFFER ASSEMBLY  
 ○ FIXTURE  
 ○ TWEEZERS  
 ○ NOTCHED SCREWDRIVER  
 ○ DRIFT PUNCH, Ø 2.4 mm  
 ○ BARREL VICE BLOCKS  
 ○ CONTROL DISK WRENCH  
 ○ HAMMER, 100 g  
 ○ FLAT HEAD SCREWDRIVER, LARGE

### ACTION VIEW

### REMARKS

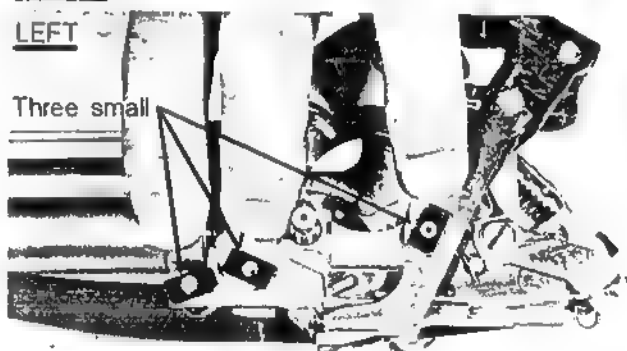
#### COMPLETING B & BA REASSEMBLY

RIGHT



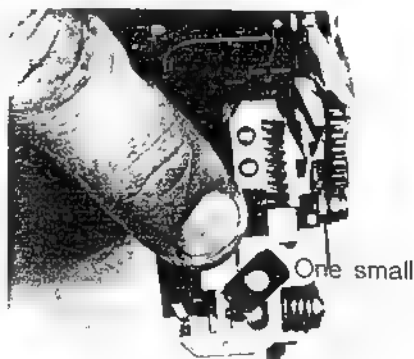
STEP 2

LEFT



STEP 2

REAR



STEP 2

1. Reinstall breech cylinder, chamber and control disk in accordance with the instructions within the operators manual.

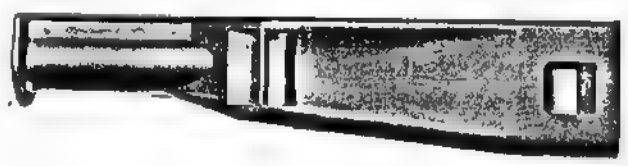
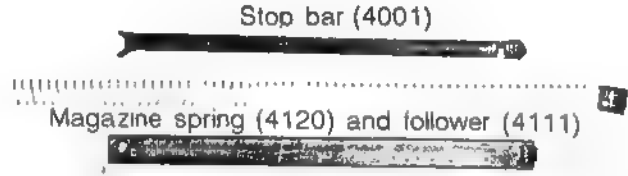
2. Check for the presence of the black holding clip on the completed B & BA.

There should be seven (7) clips total, located in the positions pictured at left.

# ARMORERS REASSEMBLY

ITEM(S): HANDGUARD (1300) AND MAGAZINE (4000)

TOOLS REQUIRED: o CLEANING KIT, HK-ACR

ACTION VIEW	REMARKS
<p data-bbox="164 535 321 578">HANDGUARD</p>  <p data-bbox="250 917 337 971">Handguard (1300)</p>	<p data-bbox="885 567 1348 644">No Disassembly or reassembly required.</p>
<p data-bbox="164 1081 305 1124">MAGAZINE</p>  <p data-bbox="439 1310 635 1343">Stop bar (4001)</p> <p data-bbox="243 1408 784 1452">Magazine spring (4120) and follower (4111)</p> <p data-bbox="431 1485 627 1517">Housing (4201)</p>	<p data-bbox="885 1113 1395 1223">Se operators manual for correct disassembly and reassembly procedures of the magazine.</p>



## ARMORERS CLEANING

The operator is not authorized to disassemble the HK-ACR beyond normal field stripping as described within the operators manual. This limitation prohibits detailed cleaning of a number of areas within the weapon that must be occasionally cleaned. Inspected and lubricated (if applicable).

Operators cleaning of the HK-ACR should occur after each firing session or after firing 500 rounds, during field use as required and after 60 days in storage.

Armorers cleaning and inspection should be conducted by the armorer after every 3000 rounds. Normal operator cleaning should be performed on the weapon before armorers cleaning takes place.

The main areas on the HK-ACR that must be cleaned by the armorer are as follows.

- o TRIGGER MECHANISM: Remove from center part and immerse in a solvent bath. Use a soft-brustled brush to loosen and remove foreign matter from between the internal parts. Air-dry and lubricate with a light coat of CLP. Circulate CLP using compressed air.
- o CENTER GUIDE: Remove from center part and clean in the same manner as the trigger mechanism. Lubricate the center guide after cleaning with a light coat of CLP.
- o CENTER PART: Immerse only the lower portion, below the carrying handle and optical sight, into a solvent bath or hot water in the absence of solvent. Use a soft-brustled brush. To remove the fouling and loose dirt. If using hot water, ensure that the water is completely removed from the part after cleaning is completed by using compressed air. Mild diswashing detergent can be used in the water to enhance cleaning. After cleaning, lubricate all metal parts using a light coat of CLP.

DO NOT IMMERSE OPTICAL SIGHT IN WATER OR SOLVENT FOR ANY REASON.

- o HANDGUARD AND BUTTSTOCK: Both handguard and buttstock can be cleaned using a solvent bath or hot, soapy water. After cleaning the buttstock, disassemble the cocking mechanism and spread a thin film of petroleum jelly between the cover (1200.5) and the outer housing. Lubricate all other moving plastic and all metal parts with a light coat of CLP, to include the heat shield located in the handguard.

## ARMORERS CLEANING (CONT)

- o BREECH AND BARREL ASSEMBLY: Remove the breech cylinder with chamber, gas plug and piston, and the buffer and buffer spring from the B & BA. Immerse the B & BA in a solvent bath and use a soft-bristled brush to dislodge loose fouling from between the parts.

Use the brass-bristled and nylon brushes to remove all traces of carbon and lead from all parts of the B & BA paying close attention to:

- o The chamber & breech cylinder
- o The opening for the breech cylinder
- o The area around the firing pin, ejector port bore and feeding orifice
- o The gas piston and plug.

After removing solvent with compressed air, lightly lubricate all parts with CLP.

- o GAS CYLINDER: Remove heavy deposits of lead and carbon from the interior of the gas cylinder using the special reamer pictured within the special tooling list. First remove the gas plug, gas piston and the gas piston return spring. To do so use a 1.9 mm Ø drift punch to remove the retaining (roll) pin and then the return spring. Insert the reamer from rear to front into the cylinder. With a circular motion, push the reamer into the cylinder as far as it will go to cut away the lead and carbon. Rinse the cylinder in solvent and lubricate with a light coat of CLP.

## ARMORERS GAUGING AND INSPECTION

Armorers inspection should be performed concurrently with detailed cleaning every 3000 rounds. Operators should be encouraged to look for signs of an unserviceable weapon and report them to the armorers. These general signs include:

- o Improper function of the rifle or individual component
- o Missing parts
- o Uncustomary looseness
- o Absence of free movement (where applicable)
- o Loss of spring tension
- o Excessive wear
- o Cracks, dents, burrs, etc.
- o Rust or corrosion
- o Absence of protective finish
- o Sudden, noticeable change in the weapons performance.

In addition to the ten general areas listed above, the armorer should closely inspect the following areas for signs of unserviceability.

- o GAS PISTON - Inspect for free movement of the gas piston within the gas cylinder. To do so, remove the H-clip that secures the rear end of the connecting rod to the actuator gear. Lift the connecting rod from the axle on the actuator gear and rotate it counter clockwise 90° (perpendicular to the barrel). Check to see that the piston (which is connected to the front end of the connecting rod) can be easily moved back and forth with the gas cylinder. If the piston does not move freely, disassemble the gas system and clean as described within armorers cleaning.
- o BUFFER - The proper function of the weapon will be impaired by an unserviceable buffer (see trouble shooting). An unserviceable buffer has lost the hydraulic fluid that allows it to function properly. The condition of the buffer can easily be checked by looking through the control hole located on the left side of the buffer housing (tube). If any brass rings of the buffer can be seen through the control hole, replace the buffer.
- o FIRING PIN - Inspect the firing pin for signs of cracks or missing material. Firing pins can be easily broken by operator abuse and therefore must be inspected regularly. Compare the firing pin in the rifle to a new spare firing pin. See trouble shooting for procedure to remove and replace the HK-ACR firing pin.

## ARMORERS GAUGING AND INSPECTION (CONT)

- o BREECH CYLINDER, CHAMBER AND OPENING FOR BREECH CYLINDER - Inspect for signs of excessive wear or gouging from propellant gases. Also, remove heavy deposits of lead and carbon using the triangular file to scrap away this material.
- o B & BA RELEASE LEVER - Check that the B & BA release lever is under spring tension and positively engages in the groove on the front tip of the buffer extension when the B & BA is assembled within the center part.
- o GENERAL -

Check for and remove any propellant particles from the interior of the outer housing and the internal parts.

The B & BA is nickel coated to prevent rust. The bore is chrome plated to decrease wear and to resist corrosion. However, inspect these areas for signs of rust from exposure to water, especially in areas where extreme wear occurs. Rust many times will appear from confined spaces in the form of brown fluid. This indicates the presence of rust. Disassemble the affected area, clean thoroughly in a solvent bath, and lubricate with rifle grease to seal out water.

## TROUBLE SHOOTING

The word "TROUBLE SHOOTING" describes the act of indentifying the cause of a malfunction within the weapon and remedying the problem with a logical solution. Before investing valuable time to trouble shoot a problem with the weapon, eliminate any potential non-mechanical reasons with the weapon that may fall within the areas listed below.

- o Improper operation by user
- o Excessively dirty
- o Lacking sufficient lubrication
- o Improper assembly
- o Missing components or parts
- o Unservicable magazine
- o Poor quality ammunition

If, after inspecting the general condition of the weapon, the rifle still fails to operate as desired, consult the following list of potential causes and suggested methods to correct them. The operators manual lists additional trouble shooting information.

PROBLEM	CAUSE	REMEDY
<hr/>		
Rounds cannot be cleared from chamber	o Solid pin missing from top of ejector where it attaches to the ejector lever	o Replace ejector
	o Bent ejector lever	o Replace ejector lever
	o Lower control bolt of control lever is missing	o Replace control lever
	o Butt stock is not in place on weapon	o When rotating control disk with the control disk wrench, push rearward on the slide to clear the ejector port and allow the ejector to push the round clear of the B & BA.
Rounds won't feed	o Broken rounds or propellant pieces in chamber preventing movement of parts.	o Clean and lubricate.
	o Cylinder stop lever and/or spring missing or defective.	o Replace one or both.

## TROUBLE SHOOTING (CONT)

PROBLEM	CAUSE	REMEDY
	<ul style="list-style-type: none"> <li>o Ejection port cover (sealing wheel) won't open when cocking handle is rotated (results from the cocking handle being forced to rate beyond 360° per rotation).</li> </ul>	<ul style="list-style-type: none"> <li>■ Check for proper alignment of alignment dots on both sealing and toothed wheels.</li> </ul>
Cocking handle rotates without resistance	<ul style="list-style-type: none"> <li>o Control disk is not present on B &amp; BA.</li> </ul>	<ul style="list-style-type: none"> <li>o Install control disk.</li> </ul>
	<ul style="list-style-type: none"> <li>o Toothed wheel is damaged due to being forced to rotate beyond 360°.</li> </ul>	<ul style="list-style-type: none"> <li>o Replace toothed wheel.</li> </ul>
Buttstock won't go on	<ul style="list-style-type: none"> <li>o Rubber gasket is out of position or damaged.</li> </ul>	<ul style="list-style-type: none"> <li>o Replace gasket.</li> </ul>
Breech cylinder cannot be installed completely in breech cylinder housing	<ul style="list-style-type: none"> <li>o Upper portion of clamping plate is broken (which releases firing pin into breech cylinder opening.</li> </ul>	<ul style="list-style-type: none"> <li>o Replace clamping plate.</li> </ul>
	<ul style="list-style-type: none"> <li>o Ejector or ejector lever is damaged or bent.</li> </ul>	<ul style="list-style-type: none"> <li>■ Replace one or both.</li> </ul>
	<ul style="list-style-type: none"> <li>o Ejector lever spring is missing or unserviceable.</li> </ul>	<ul style="list-style-type: none"> <li>o Replace spring.</li> </ul>
Cocking handle (or breech cylinder) will not rotate	<ul style="list-style-type: none"> <li>o Partially ignited round stuck in chamber, tip of bullet stuck in bore. (Failure to ignite booster - F.T.I.B.)</li> </ul>	<ul style="list-style-type: none"> <li>- Try or clear weapon</li> <li>- Remove B &amp; BA from center part</li> <li>- Open catch</li> <li>- Assemble cleaning rod with handle, three sections and the control rod.</li> <li>- Insert cleaning rod into muzzle and push bullet back into cartridge body</li> <li>- Remove breech cylinder and chamber</li> <li>- Remove particles of propellant from weapon. Clean &amp; lube.</li> </ul>

## TROUBLE SHOOTING (CONT)

PROBLEM	CAUSE	REMEDY
	o Broken clamping plate (firing pin blocks rotation of breech cylinder)	o Replace clamping plate (to remove breech cylinder, rotate firing pin from back of B & BA with tweezers. Inspect firing pin for damage.)
	o Broken ejector or bent ejector lever.	o Replace affected part.
	o Top of slide is damaged or missing (rounds feed too far through chamber).	o Replace slide.
Cadence of fully-automatic fire is irregular or too fast	o Buffer is unserviceable (see inspection)	o Replace buffer.
Cloud of white smoke erupts from weapon while firing, abnormally mild recoil, faint report.	o Failure of chamber due to wear, fouling or lack of lubrication	<ul style="list-style-type: none"> <li>- Replace chamber</li> <li>- Inspect breech cylinder opening for gouging due to gas jet from failed chamber.</li> </ul>

NOTE: CHAMBER MUST BE KEPT PROPERLY LUBRICATED TO ALLOW THE CHAMBER AND ITS CAP TO EXPAND DURING FIRING. LUBRICATE THE CHAMBER USING THE CLP BOTTLE WITH THE PLASTIC EXTENSION. CLEAR THE WEAPON, LEAVE CHAMBER IN FEEDING POSITION (EJECTION PORT OPEN) INSERT EXTENSION FULLY INTO WEAPON AND SQUEEZE ONCE.

IT IS RECOMMENDED TO LUBE THE CHAMBER EVERY 200 ROUNDS IN THIS MANNER.



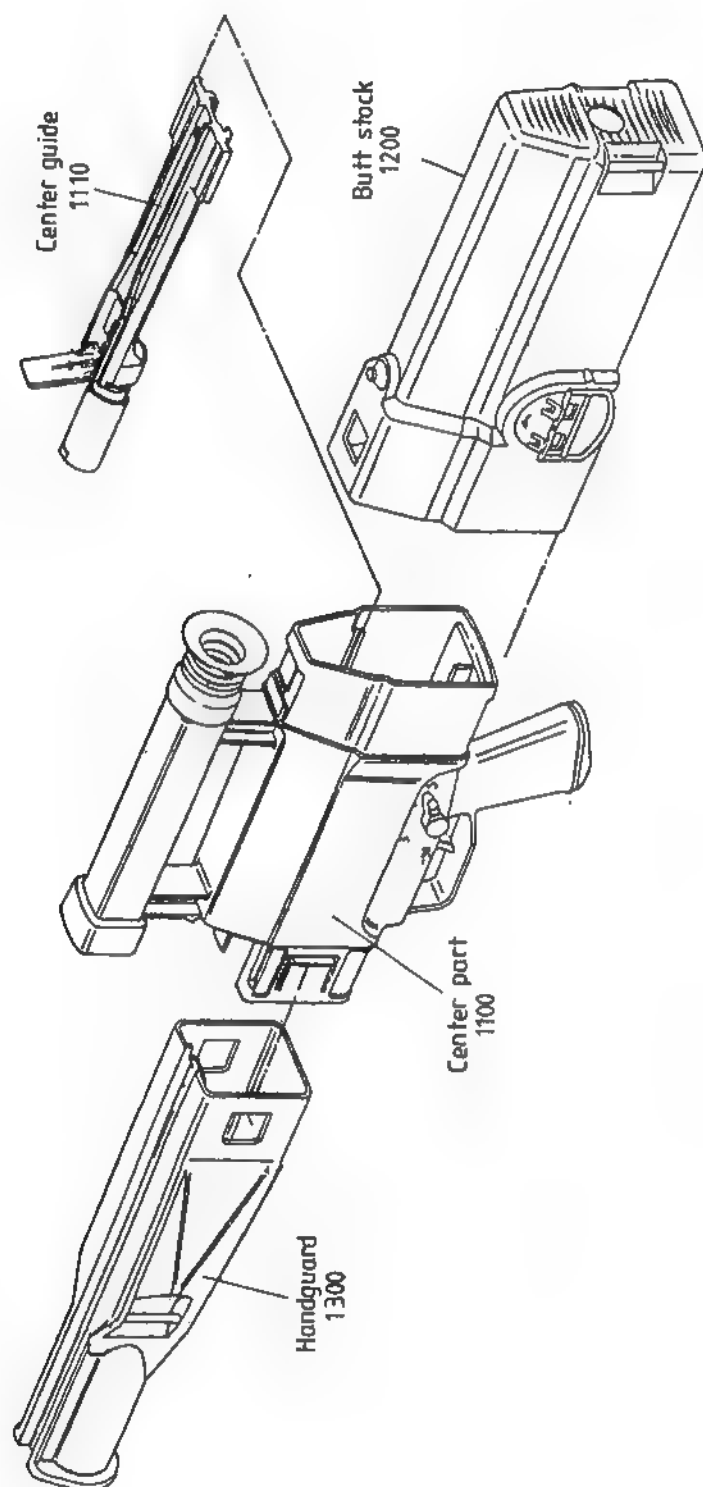
## TROUBLE SHOOTING (CONT)

PROBLEM	CAUSE	REMEDY
Weapon fails to fire all rounds when trigger is pulled.	o Failure to rotate breech cylinder (F.T.R.B.C.) due to heavy fouling of breech of breech cylinder.	o Remove heavy fouling with brass brush and triangular file and lubricate with CLP bottle and plastic extension.
Weapon does not fire or ignite primer	o Broken firing pin (Occurs when: - More than three cleaning rod sections are used with handle and brush to clean bore - or if an attempt is made to remove breech cylinder with firing pin uncocked.)	- Place catch in middle position (between closed and open positions). - Remove and replace firing pin as described within this manual.

HK-ACR

HOUSING

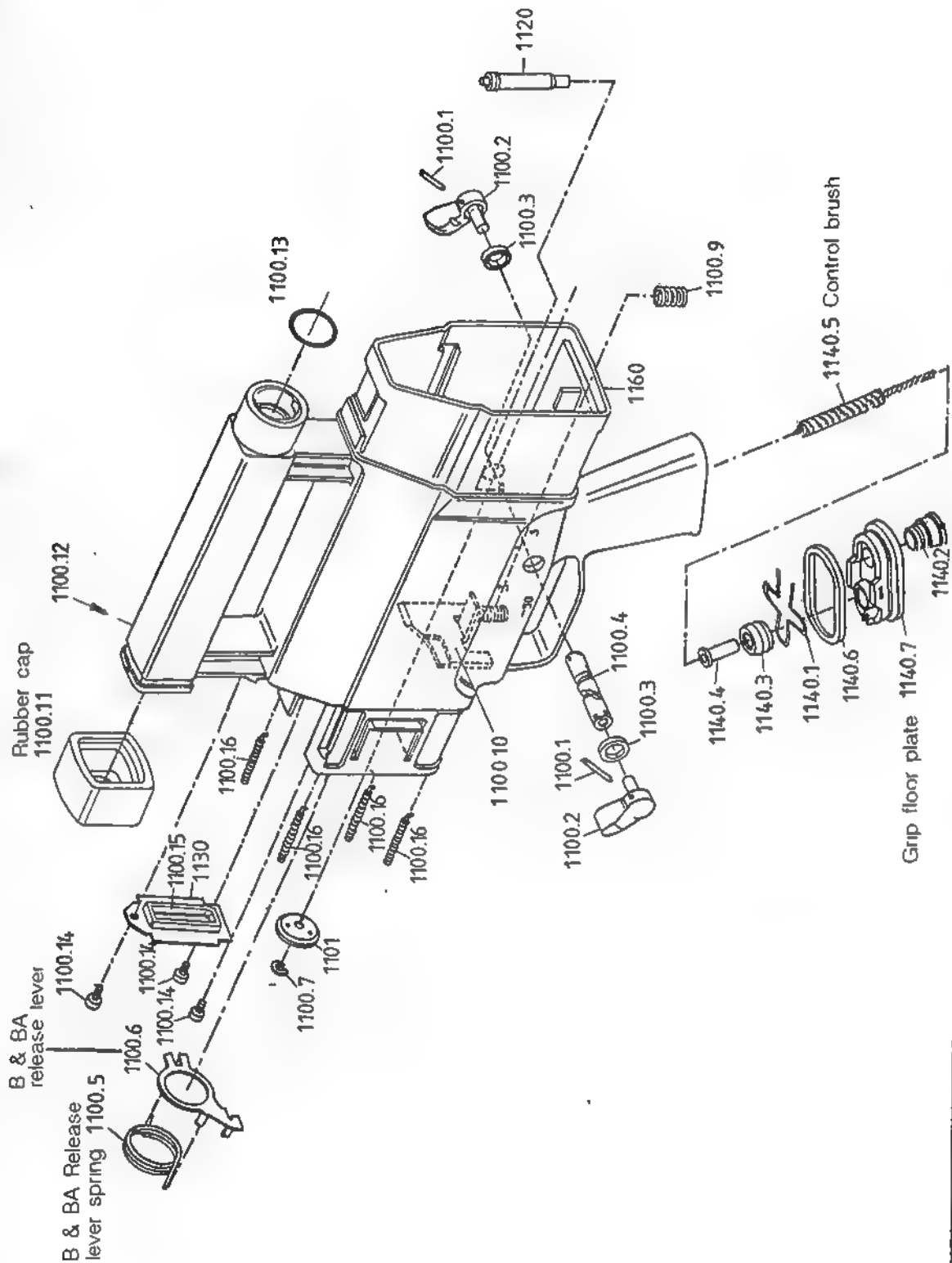
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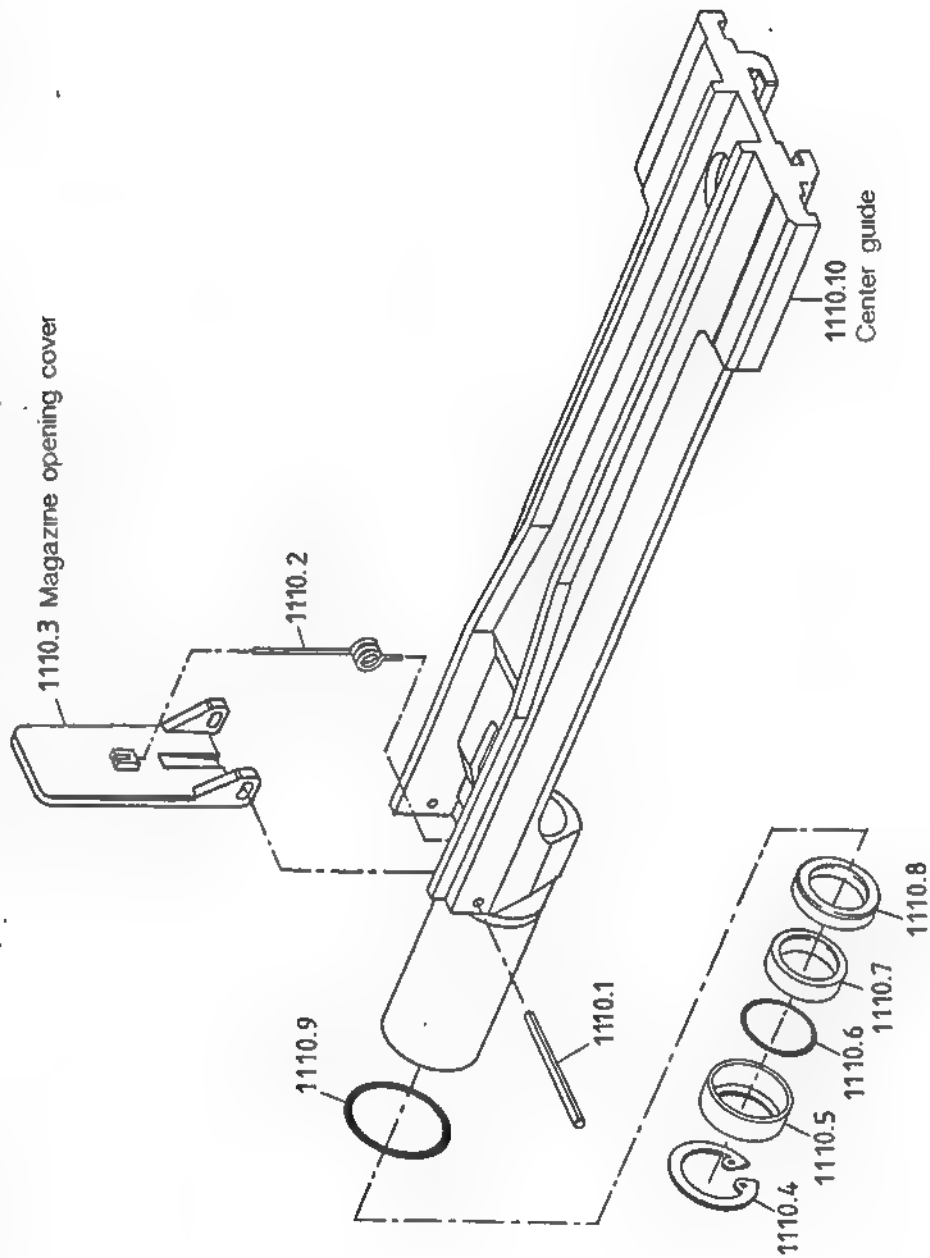


# HK-ACR

## CENTER PART

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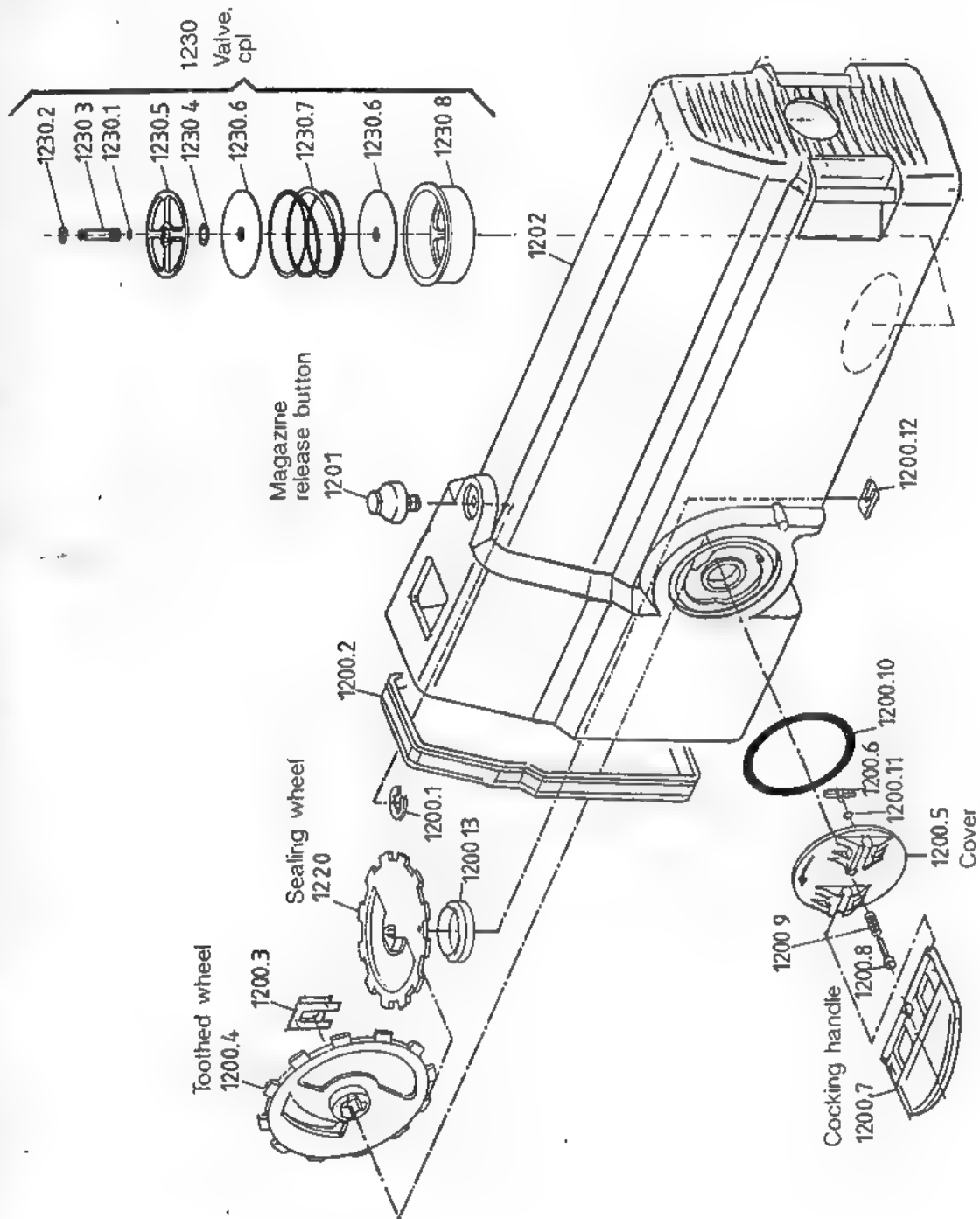




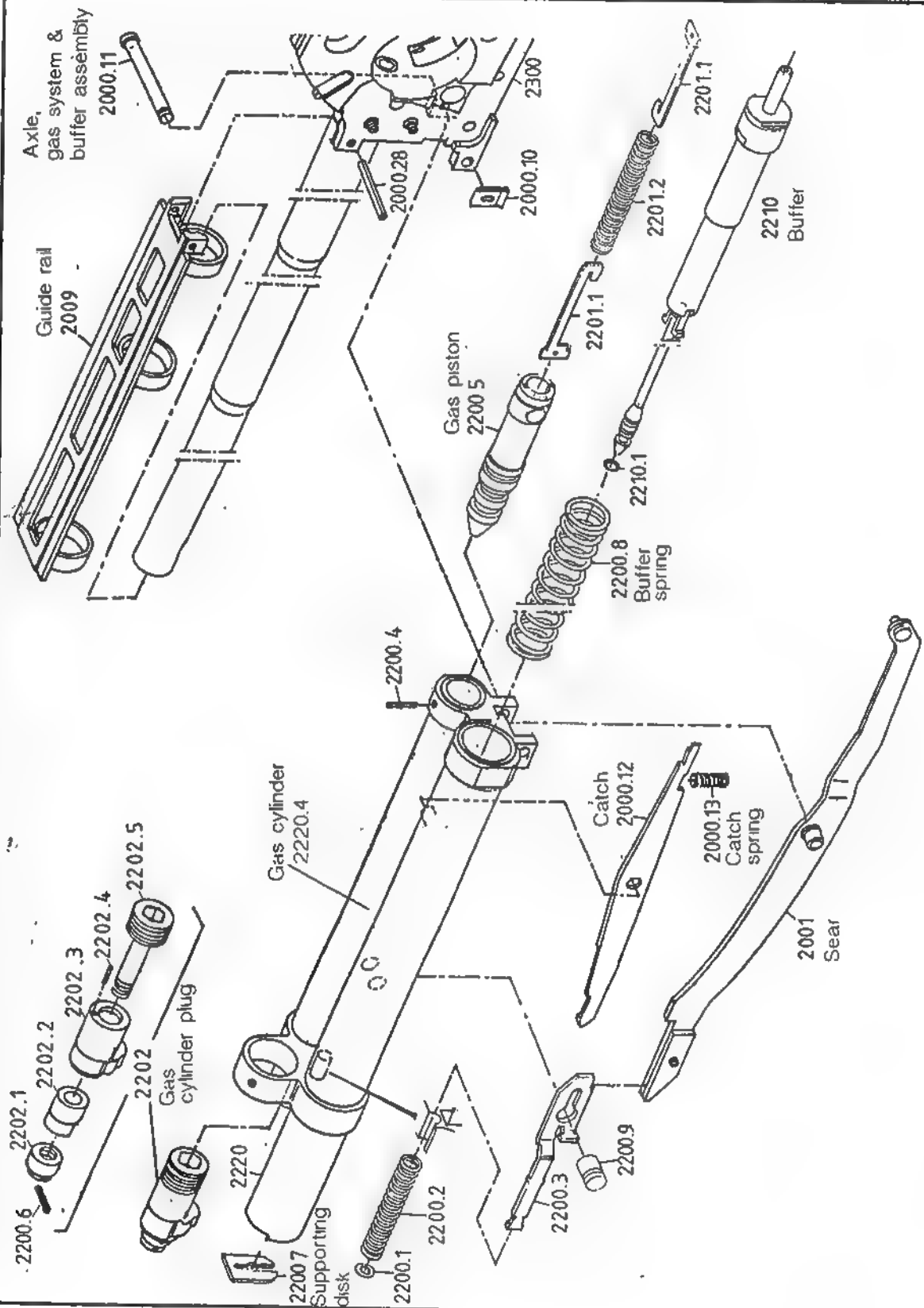
HK-ACR

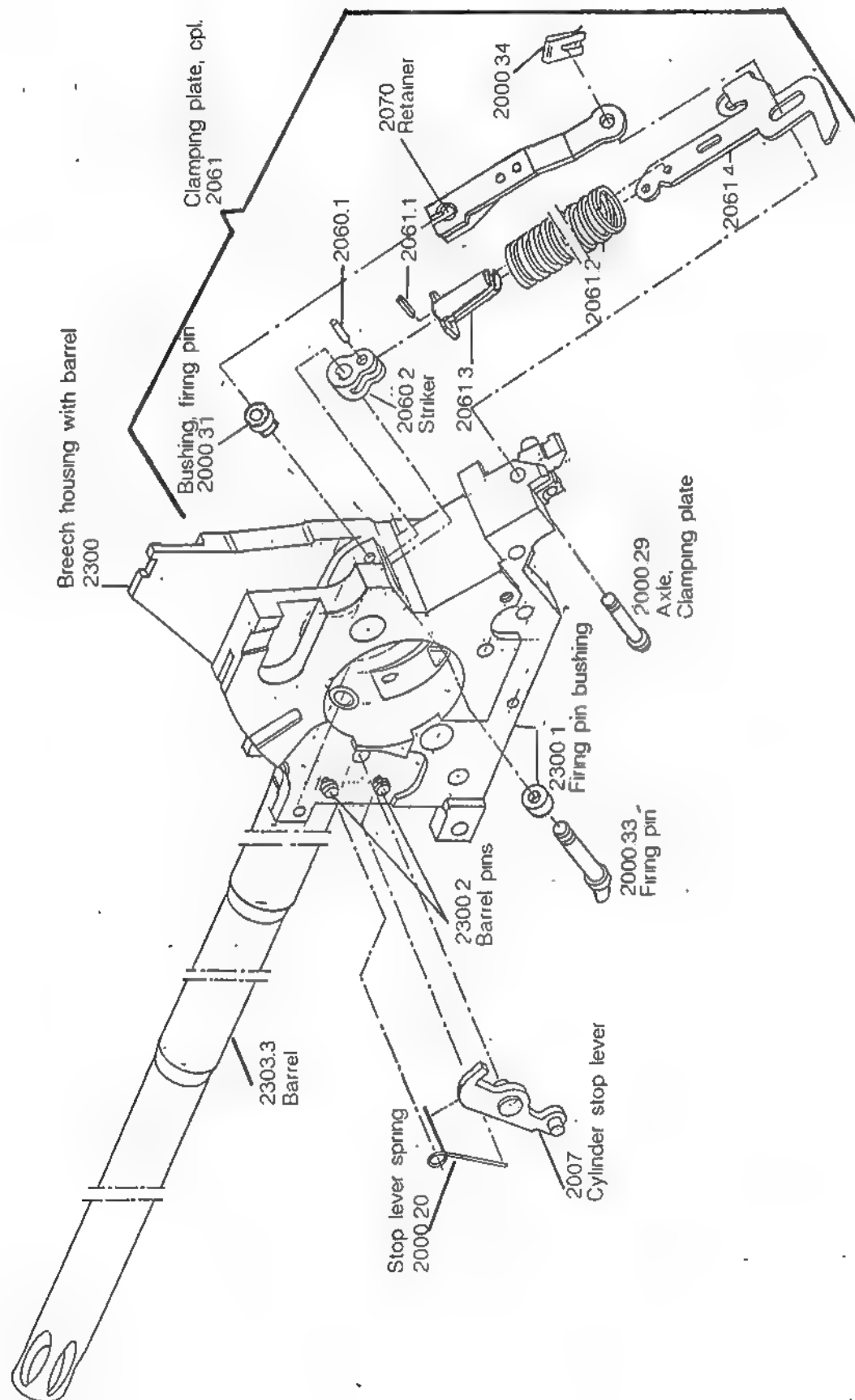
BUTT STOCK COMPL.

1200



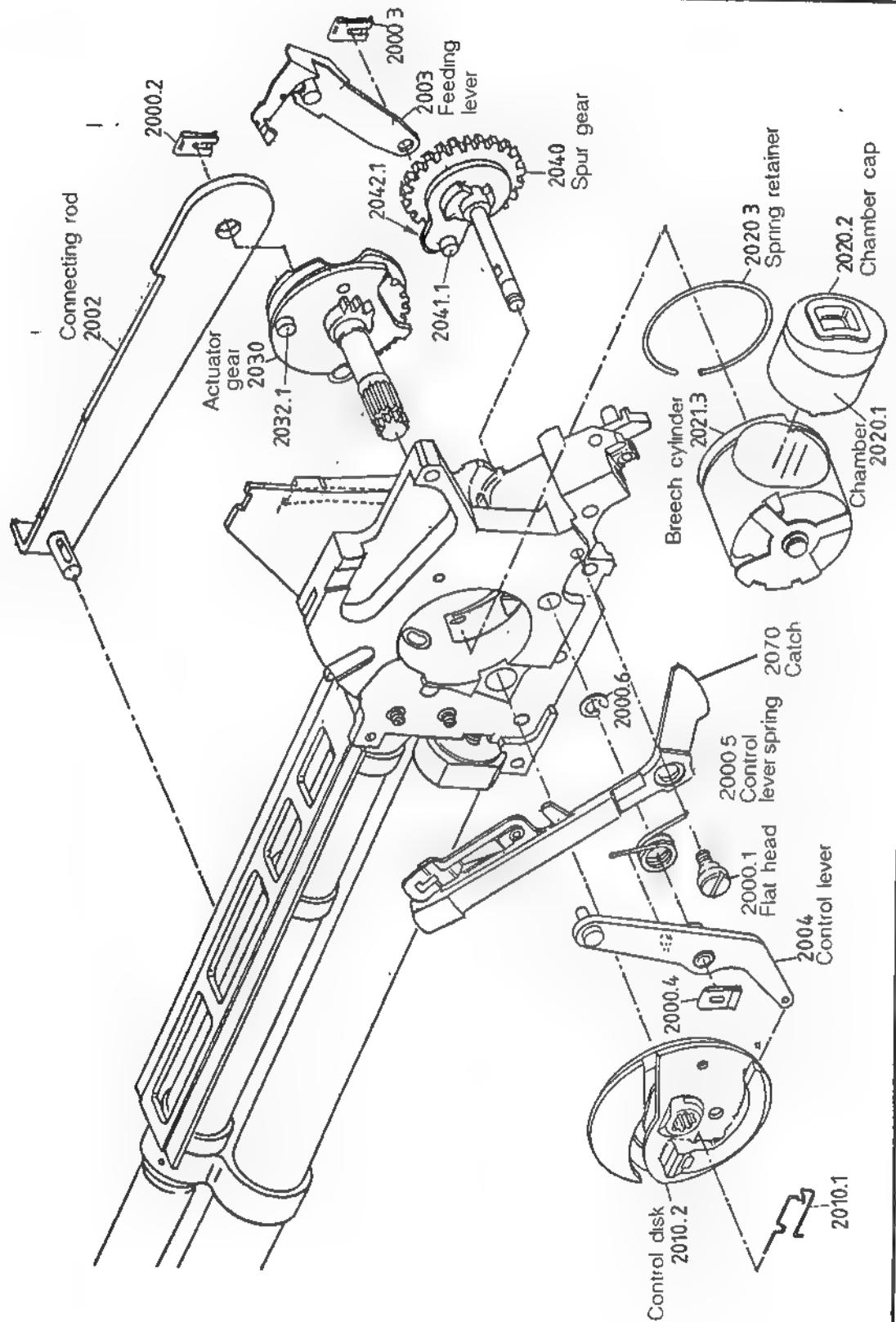
# HK-ACR BREECH & BARREL ASSEMBLY (B & BA) 2000



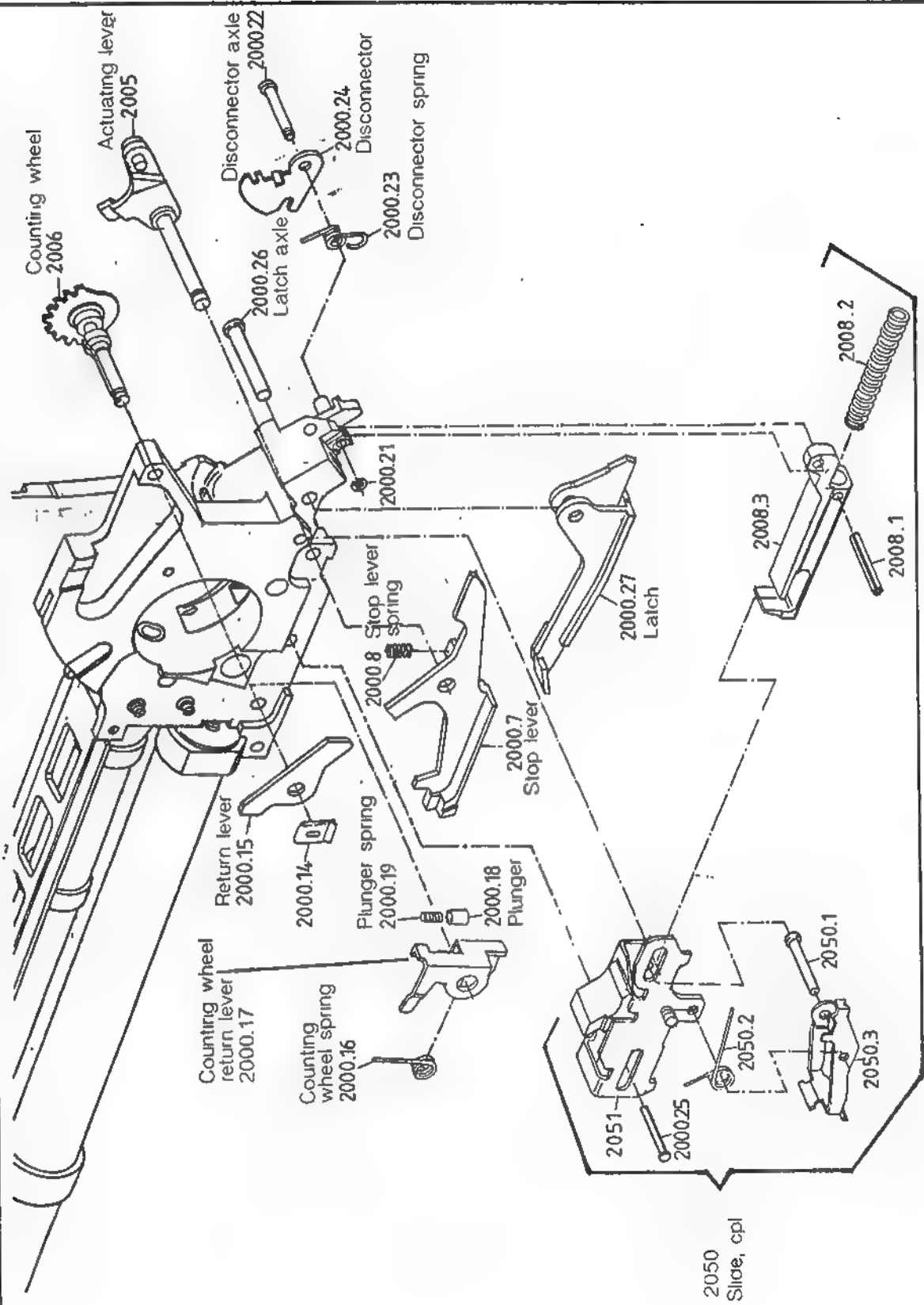




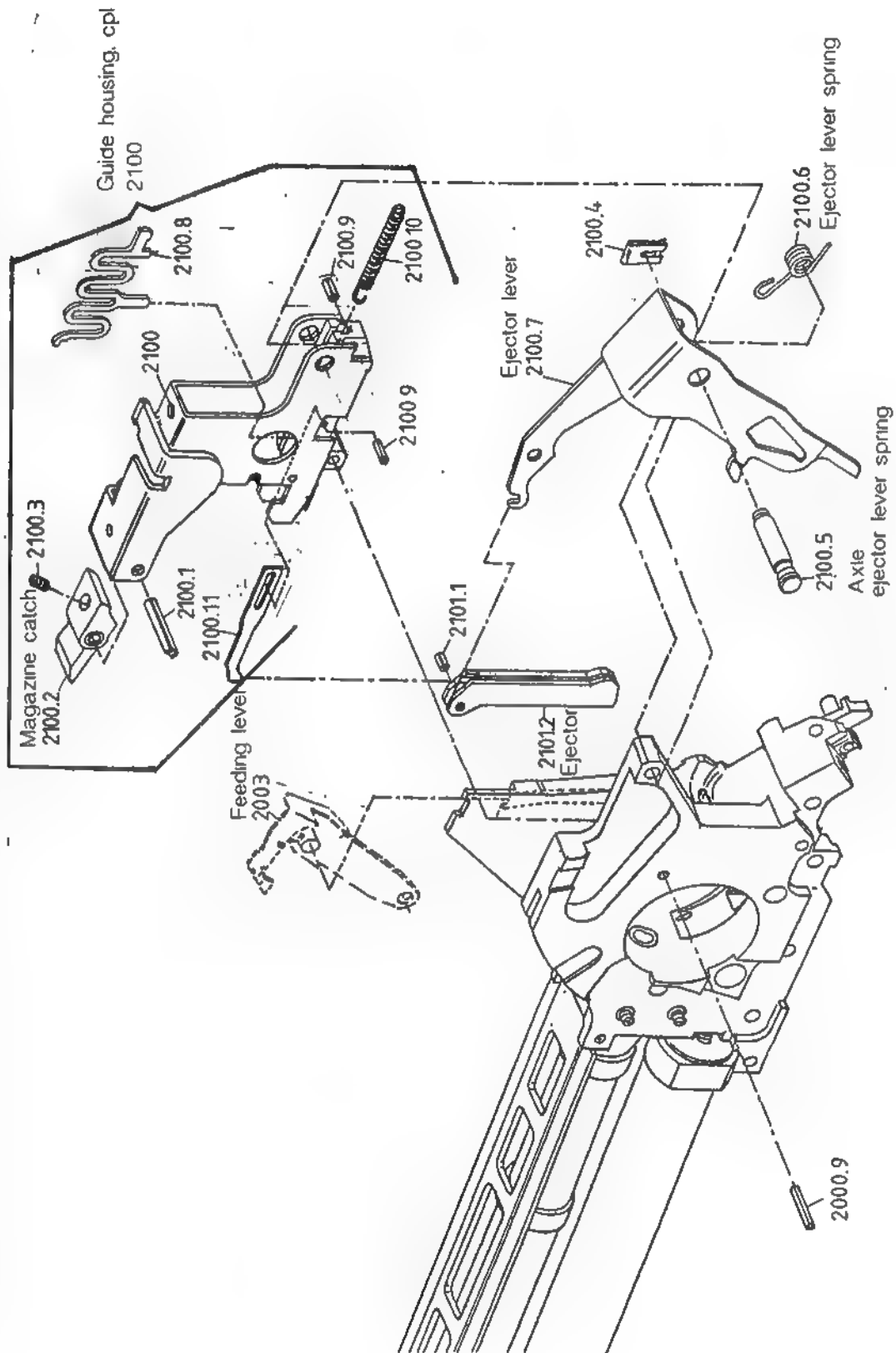
# HK-ACR BREECH & BARREL ASSEMBLY (B & BA) 2000



# HK-ACR BREECH & BARREL ASSEMBLY (B & BA) 2000



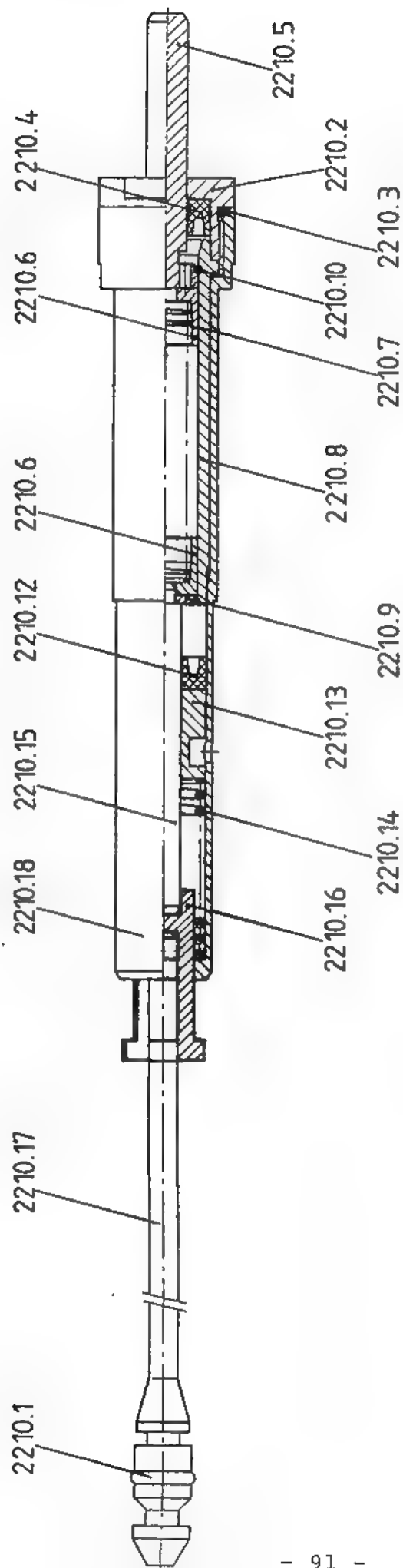
# HK-ACR BREECH & BARREL ASSEMBLY (B & BA) 2000



HK-ACR

BREECH & BARREL ASSEMBLY (B & BA)

2000



BUFFER 2210

TRIGGER HOUSING, COMPL:

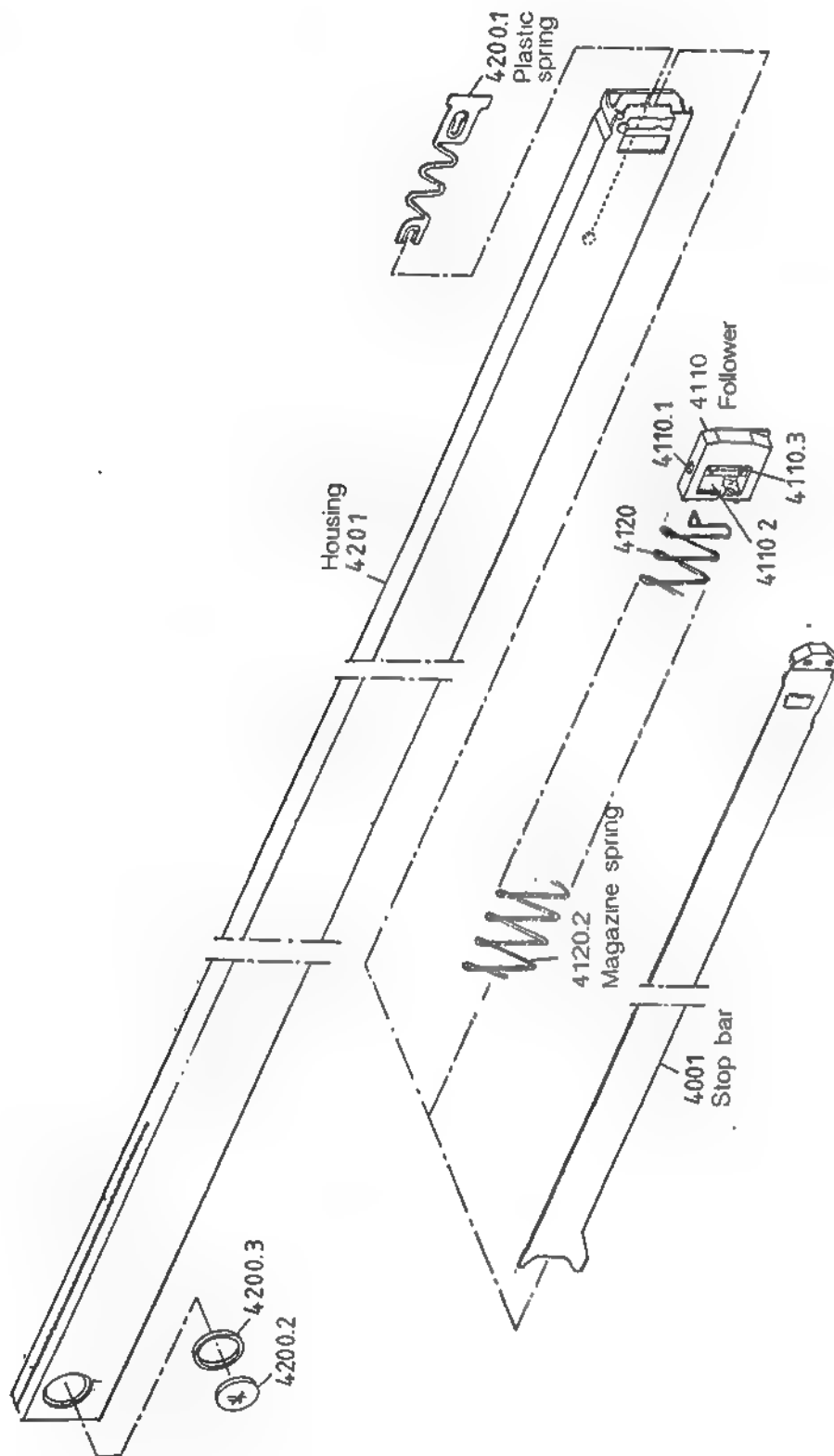
This diagram illustrates the exploded view of a mechanical assembly, showing the relationship between various components. The parts are identified by the following numbers:

- 3000.1: A long cylindrical shaft or pin.
- 3000.2: A smaller cylindrical pin.
- 3000.3: A bracket or support arm.
- 3000.4: A small cylindrical pin.
- 3000.5: A small cylindrical pin.
- 3000.6: A small cylindrical pin.
- 3000.7: A small cylindrical pin.
- 3000.8: A small cylindrical pin.
- 3000.9: A bracket or support arm.
- 3000.10: A small cylindrical pin.
- 3000.11: A small cylindrical pin.
- 3000.12: A bracket or support arm.
- 3001: A circular end plate or cap.
- 3002.1: A small cylindrical pin.
- 3002.2: A small cylindrical pin.
- 3002.3: A small cylindrical pin.
- 3002.4: A small cylindrical pin.
- 3002.5: A small cylindrical pin.
- 3002.6: A small cylindrical pin.
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- 3002.40: A small cylindrical pin.
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- 3002.92: A small cylindrical pin.
- 3002.93: A small cylindrical pin.
- 3002.94: A small cylindrical pin.
- 3002.95: A small cylindrical pin.
- 3002.96: A small cylindrical pin.
- 3002.97: A small cylindrical pin.
- 3002.98: A small cylindrical pin.
- 3002.99: A small cylindrical pin.
- 3003: A bracket or support arm.

HK-ACR

MAGAZINE COMPL.

4000



# HK-ACR PART REFERENCE NUMBERS

## HK-ACR

1000	Housing
2000	Breech & Barrel Assembly (B & BA)
3000	Trigger Mechanism
4000	Magazine
5000	Scope
6000	Carrying Sling

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
1000	Housing, complete	
1100	Center part, complete	
1110	Center guide, complete	12 557 536
1110.1	Clamping pin	DIN 7436 2x30
1110.2	Elbow spring	12 557 539
1110.3	Magazine opening cover	12 557 538
1110.4	Circlip SB 18	---
1110.5	Sealing housing	12 557 541
1110.6	O-ring 14x1.3	---
1110.7	Barrel seal	12 557 542
1110.8	Barrel guide	12 557 540
1110.9	O-ring 18x1.5	---
1110.10	Center guide	12 557 537
1100.1	Clamping pin	Din 1481 1.5x16
1100.2	Safety lever	12 557 526
1100.3	Slotted ring	Z8 R80 1610
1100.4	Safety cylinder	12 557 527
1100.5	B & BA release lever spring	12 557 518
1100.6	B & BA release lever	12 557 519
1100.7	C-clip	DIN 6799-2.3
1101	Valve disk	12 557 532
1101.1	Disk	12 557 550
1100.8	Bolt	12 557 520
1100.9	Compression spring	12 557 530
1100.10	Slide	12 557 529
1100.9	Compression spring	12 557 530
1120	Thrust bolt, complete	12 557 534
1120.1	Circular sealing ring	4.4x0.8 NB70
1120.2	Compression spring	12 557 546
1120.3	Thrust bolt	12 557 547
1120.4	Spring housing	12 557 545
1100.11	Rubber cap	12 557 524
1100.12	Pin	12 557 598
1100.13	O-ring 28.5x1.5	28.5x1.8
1100.14	Lens head screw	DIN 7985 M2x5
1130	Front plate, complete	12 557 533
1130.1	Ramp	12 557 549
1130.2	Front plate	12 557 548



# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
1102	Magazine sealing, complete	12 557 609
1102.1	Frame	12 557 610
1140	Grip floor plate, complete	12 557 579
1140.1	Spring	12 557 581
1140.2	Pin	12 557 582
1140.3	Seal	12 557 583
1140.4	Bushing	12 557 584
1140.5	Control brush	12 557 585
1140.6	Dampening ring	12 557 586
1140.7	Grip floor plate	12 557 580
1150	Control stick, complete	12 557 587
1150.1	Tightener	12 557 588
1150.2	Intermediate element	12 557 589
1150.3	Head	12 557 590
1150.4	Top	12 557 591
1150.5	Rope	Art.Nr. 1655 of Messrs. Edelmann & Ridder
1100.16	Compression spring	12 557 528
1100.17	Carrying plate	12 557 592
1160	Center part	12 557 531
1160.1	Insert	12 557 543
1160.2	Threaded bushing	SM3 DIN 16903-MS1
1160.3	Bushing	12 557 577
1200	Buttstock, complete	12 557 557
1200.1	C-clip	DIN 6799-3.2
1201	Magazine release button	12 557 555
1201.1	Push bolt	12 557 556
1200.2	Seal for points of intersection	12 557 567
1200.3	Flat spring	12 557 566
1200.4	Toothed wheel	12 557 565
1200.5	Cover	12 557 560
1200.6	Positioner	12 557 564
1200.7	Cocking handle	12 557 563
1200.8	Spring bolt	12 557 562
1200.9	Compression spring	12 557 561
1200.10	Spacer ring	12 557 559
1200.11	O-ring 2.2x1	---

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
1200.12	Flat spring	12 557 352
1220	Sealing wheel	12 557 551
1220.1	Segment	12 557 553
1220.2	Pivot	12 557 554
1220.3	Sealing wheel	12 557 552
1120.4	O-ring 2.2x1	O-ring 2.2x1
1200.13	Socket	12 557 558
1200.14	C-clip	DIN 6799-3.2
1200.15	Cover	12 557 607
1230	Valve, complete	12 557 599
1230.1	O-ring 2.2x1	
1230.2	C-clip	DIN 6799-3.2
1230.3	Bolt	12 557 601
1230.4	Circlip	Seeger SW6
1230.5	Centering disk	12 557 604
1230.6	Filter plate	12 557 602
1230.7	Compression spring	12 557 603
1230.8	Casing	12 557 600
1200.16	Clamping ring	12 557 608
1200.17	Sealing ring	12 557 605
1200.18	Intermediate ring	12 557 606
1200.19	O-ring 45x2	---
1202	Buttstock riveted	
1202.1	Rivet	DIN 662-3x6 AL
1202.2	Retaining piece	15 557 573
1202.3	Buttstock	12 557 572
1300	Handguard, complete	12 557 569
1300.1	Handguard	12 557 570
1300.2	Bushing	12 557 579
2000	Breech & Barrel Assembly (B & BA)	---
2010	Control disk, complete	12 557 436
2010.1	Spring	12 557 437
2010.2	Control disk welded	12 557 438
2011.1	Wedge	12 557 447
2011.2	Control disk	12 557 446

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
2020	Breech cylinder with chamber	---
2020.1	Chamber	12 557 376
2020.2	Chamber cap	12 557 576
2020.3	Spring retainer	12 557 375
2021	Breech cylinder, complete	12 557 337
2021.1	Rivet	12 557 409
2021.2	Bearing disk	12 557 408
2021.3	Breech cylinder	12 557 407
2001	Sear, complete	12 557 358
2001.1	Clamping pin	DIN 7343-2.5x5
2001.2	Bolt	12 557 365
2001.3	Bushing	12 557 366
2001.4	Plate	12 557 367
2001.5	Sear	12 557 364
2000.2	H-clip, large	12 557 575
2002	Connecting rod	12 557 374
2002.1	Bolt	12 557 406
2002.2	Pin	12 557 404
2002.3	Connecting rod	12 557 405
2030	Actuator gear	12 557 415
2031	Driving wheel solderer	12 557 416
2031.1	Axle	12 557 420
2031.2	Toothed wheel	12 557 419
2031.3	Driving wheel	12 557 418
2032	Driving disk soldered	12 557 417
2032.1	Bearing bolt	12 557 422
2032.2	Driving disk	12 557 421
2000.3	H-clip, small	12 557 352
2003	Feeding lever, complete	12 557 428
2003.1	Guide bolt	12 557 430
2003.2	Feeding lever	12 557 429
2000.4	H-clip, small	12 557 352
2004	Control lever, complete	12 557 431
2004.1	Receiving bushing	12 557 433
2004.2	Guide bolt	12 557 434
2004.3	Control bolt	12 557 435
2004.4	Control lever	12 557 432
2000.5	Control lever spring	12 557 381
2000.6	C-clip, large	
2040	Spur gear, complete	12 557 423

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
2041	Actuator, complete	12 557 424
2041.1	Bolt	12 557 427
2041.2	Actuator	12 557 426
2042	Spur gear finished	12 557 425
2042.1	Retaining pin	12 557 445
2042.2	Spur gear	12 557 444
2005	Actuating lever, complete	12 557 448
2005.1	Bearing bolt	12 557 450
2005.2	Guide bolt	12 557 451
2005.3	Actuating lever	12 557 449
2000.7	Stop lever	12 557 379
2000.8	Stop lever spring	12 557 400
2000.9	Clamping pin	DIN 7346-2.5x22
2100	Guide housing, complete	---
2100.1	Clamping pin	DIN 7346-3x18
2100.2	Magazine catch	12 557 349
2100.3	Compression spring	12 557 350
2100.4	H-clip, small	12 557 352
2100.5	Ejector axle	12 557 346
2100.6	Ejector lever spring	12 557 347
2100.7	Ejector lever	12 557 345
2100.8	Spring	12 557 351
2101	Push rod, complete	12 557 353
2101.1	Clamping pin	DIN 7344-2x4
2101.2	Ejector	12 557 354
2100.9	Clamping pin	DIN 7346-2x6
2100.10	Compression spring	12 557 348
2100.11	Stop	12 557 344
2102	Guide housing welded	12 557 336
2102.1	Guide receiver	12 557 337
2102.3	Reinforcement member	12 557 339
2102.3	Guide housing	12 557 338
2000.10	H-clip, small	12 557 352
2000.11	Gas system and buffer assembly axle	12 557 371
2000.12	Catch	12 557 372
2000.13	Catch spring	12 557 369

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
2200	Counterrecoil mechanism	12 557 307
2200.1	Disk	12 557 614
2200.2	Compression spring	12 557 613
2200.3	Drop safety	12 557 611
2200.4	Clamping pin	DIN 1481 2x18
2201	Compression spring, complete	12 557 313
2201.1	Rod	12 557 316
2201.2	Compression spring	12 557 318
2200.5	Gas piston	12 557 308
2000.6	Cylindrical pin	wire 2x12
2202	Gas cylinder plug	12 557 593
2202.1	Bushing	12 557 595
2202.2	Cylinder	12 557 596
2202.3	Nut	12 557 597
2202.4	Clamping pin	DIN 1481 1.5x6
2202.5	Screw	12 557 594
2200.7	Supporting disk	12 557 312
2210	Buffer	12 557 314
2210.1	Circular seal	o-ring 4x1
2210.2	Buffer screw	12 557 329
2210.3	Circular seal	o-ring 12x1.5
2210.4	Sealing ring	S 59999.3014-109
2210.5	Piston bolt	12 557 324
2210.6	Piston	12 557 326
2210.7	Compression spring	12 557 328
2210.8	Nozzle body	12 557 327
2210.9	Disk	12 557 615
2210.10	Circlip	DIN 7393 B8
2210.11	Hydraulic oil	LM DM PS 20
2210.12	Sealing ring	S 59999-2739-109
2210.13	Bearing	12 557 323
2210.14	Compression spring	12 557 322
2210.15	Piston bolt	12 557 325
2210.14	Clevis pin	12 557 321
2210.17	Rod	12 557 320
2210.18	Buffer housing	12 557 319
2200.8	Buffer spring	12 557 310
2200.9	Roller	12 557 612

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
2220	Gas system and buffer assembly	12 557 315
2220.1	Bearing	12 557 330
2220.2	Rear bearing	12 557 331
2220.3	Pivot pin	12 557 332
2220.4	Gas cylinder	12 557 333
2220.5	Web	12 557 334
2221	Tubular guide welded	12 557 335
2221.1	Cover	12 557 342
2221.2	Tubular guide	12 557 341
2000.14	H-clip, small	12 557 352
2000.15	Return lever	12 557 401
2006	Counting wheel, complete	12 557 340
2006.1	Bolt	12 557 411
2006.2	Counting wheel	12 557 410
2000.16	Counting wheel spring	12 557 384
2000.17	Counting wheel return lever	12 557 382
2000.18	Plunger	12 557 383
2000.19	Plunger spring	12 557 385
2000.20	Cylinder stop lever spring	12 557 380
2007	Cylinder stop lever	12 557 412
2007.1	Stop bolt	12 557 414
2007.2	Stop lever	12 557 413
2000.21	C-clip, small	DIN 6799-1.9
2000.22	Disconnecter axle	12 557 387
2000.23	Disconnecter spring	12 557 370
2000.24	Disconnecter	12 557 387
2008	Spring guide, complete	12 557 452
2008.1	Clamping pin	DIN 7346-2.5x8
2008.2	Compression spring	12 557 454
2008.3	Spring guide	12 557 453
2000.25	Cylindrical pin	12 557 398
2050	Slide, complete	12 557 455
2050.1	Axle	12 557 458
2050.2	Elbow spring	12 557 457
2050.3	Clevis	12 557 456
2051	Slide welded	12 557 459
2051.1	Pin	12 557 463
2051.2	Bushing	12 557 461
2051.3	Reinforcement member	12 557 462
2051.4	Slide	12 557 460

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
2000.26	Latch axle	12 557 388
2000.27	Latch	12 557 402
2000.28	Clamping pin	DIN 7344-2.5x24
2009	Clamping plate axle	12 557 304
2009.1	Ring	12 557 306
2009.2	Bar	12 557 305
2000.29	Clamping plate axle	12 557 397
2000.31	Bushing, firing pin	12 557 389
2000.33	Firing pin	12 557 391
2060	Clamping plate with striker	---
2060.1	Cylindrical pin	12 557 393
2060.2	Striker	
2061	Clamping plate, complete	---
2061.1	Pin	12 557 403
2061.2	Compression spring	12 557 394
2061.3	Spring bearing	12 557 396
2061.4	Clamping plate	12 557 395
2000.34	H-clip, small	
2065	Retainer	
2000.1	Flat head screw	12 557 399
2070	Catch, complete	12 557 355
2070.1	Rivet	DIN 674-2.6x4.5 St
2070.2	Stop spring	12 557 357
2070.3	Catch	12 557 356
2300	Breech cylinder housing with barrel	12 557 439
2300.1	Bushing	12 557 443
2300.2	Barrel pin	12 557 442
2300.3	Barrel	12 557 441
2300.4	Breech cylinder housing	12 557 440
3000	Trigger case, complete	
3000.1	Cylindrical pin	12 557 478
3010	Release lever, complete	---
3010.1	Axle	12 557 468
3010.2	Elbow spring	12 557 469
3011	Release latch, complete	12 557 483
3011.1	Bushing	12 557 488
3011.2	Release latch	12 557 487
3010.3	Cylindrical pin	12 557 481
3010.4	Release lever	12 557 466

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
3001	Trigger seal, complete	12 557 482
3001.1	Plate	12 557 486
3020	System locking lever, compl.	12 557 484
3020.1	Collar bushing	12 557 490
3020.2	Pin	12 557 616
3020.3	System locking lever	12 557 489
3000.2	Elbow spring	12 557 470
3000.3	Catch	12 557 473
3000.4	Compression spring	12 557 474
3000.1	Cylindrical pin	12 557 478
3000.5	Elbow spring	12 557 471
3000.6	Cylindrical pin	12 557 479
3000.7	Roller	12 557 475
3000.8	Roller	12 557 476
3000.9	Latch	12 557 617
3002	Trigger, complete	---
3002.1	Flat spring	12 557 477
3002.2	Trigger	12 557 467
3000.10	Cylindrical pin	12 557 480
3000.11	Lever for tilt control	12 557 465
3000.10	Cylindrical pin	12 557 480
3003	Control slide, complete	12 557 485
3003.1	Bolt	12 557 492
3003.2	Control slide	12 557 491
3000.12	Trigger	12 557 472
4000	Magazine	12 557 493
4001	Stop bar, complete	12 557 496
4001.1	Countersunk rivet	12 557 514
4001.2	Stop head	12 557 513
4001.2	Stop bar	12 557 512
4100	Magazine spring, complete	12 557 495
4110	Follower, complete	12 557 497
4110.1	Follower axle	12 557 501
4510.2	Follower catch	12 557 499
4110.3	Follower bolt	12 557 500
4110.4	Compression spring	12 557 502



# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
4111	Follower	---
4111.1	Insert	12 557 503
4111.2	Follower	12 557 498
4120	Magazine spring	---
4120.1	Heat shrinking hose	12 557 505
4120.2	Magazine spring	12 557 504
4200	Magazine housing, complete	12 557 494
4200.1	Plastic spring	12 557 506
4200.2	Glass	12 557 507
4200.3	Seal	of Messrs. Muenchmeyer
4201	Magazine housing, welded	12 557 508
4201.1	Magazine housing	12 557 509
4201.2	Magazine floor plate	12 557 510
4201.3	Rivet bolt	12 557 511
5000	Scope, complete	12 557 826 (-803)
5000.1	Screw ring	12 557 993
5000.3	O-Ring	O-26x1
5000.4	Spring washer	12 558 007
5001	Tube complete	
5001.1	Tube	12 558 004
5001.2	Tube	12 558 005
5000.5	Screw pin	DIN 553 M2x2.5
5000.6	Cylindrical screw	DIN 920 M2x6
5000.7	Compression spring	12 557 990
5000.8	Click in ring	12 557 880
5100	Curved tube, complete	12 557 827
5100.1	Eye cap	-
5110	Cover glass, framed	12 557 828
5111	Cover glass	12 557 956
5111.1	Cover glass, blank	12 558 018
5110.1	Screw ring	12 557 962
5100.2	O-Ring	O-22x2.5
5120	Exit pupil framed	12 557 833
5120.1	O-Ring	O-13x1.5
5120.2	Front ring	12 557 967
5120.3	Light stop	12 557 972

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
5121	Exit pupil lens	12 557 834
5121.1	Exit pupil lens 1	12 557 952
5121.1-1	Pressed part for exit pupil lens 1	12 558 015
5121.2	Exit pupil lens 2	12 557 953
5121.2-1	Pressed part for exit pupil lens 2	12 558 016
5120.4	Spacer ring	12 557 968
6122	Exit pupil lens 3	12 557 954
5122.1	Pressed part for exit pupil lens 3	12 558 017
5120.5	O-Ring	O-13.5x0.8
5120.5	Frame	12 557 966
5100.3	Countersunk screw	DIN 963 M2x6
5100.4	Knurled ring	12 557 965
5100.5	Partition ring, engraved	12 557 997
5100.6	Compression spring	12 558 001
5100.7	Thrust piece	12 558 009
5100.8	Screwed pin	DIN 553 M2x2
5100.9	Front ring	12 557 963
5100.10	Countersunk screw	DIN 963 M2x6
5100.11	Retaining member	12 557 970
5100.12	Countersunk screw	DIN 963 M2x7
5100.13	Retaining member	12 557 969
5130	RLS 1, framed	12 557 829
5131	RLS 1, fixed	12 557 830
5131.1	RLS 1 flint	12 557 958
5131.1-1	Pressed part for RLS lens 1	12 558 020
5131.2	RLS 1 kron	12 557 959
5131.2-1	Pressed part for RLS lens 2	12 558 021
5130.1	Frame	12 557 977
5140	RLS 2 framed	12 557 831
5141	RLS 2	12 557 832
5141.1	RLS 2 flintlens	12 557 950
5141.1-1	Pressed part for RLS 2 flintlens	12 558 013
5141.2	RLS 2 kronlens	12 557 951
5141.2-1	Pressed part for RLS 2 kronlens	12 558 014
5150	Guide with click in	12 557 835
5150.1	Ring	12 558 008
5150.2	Guide	12 557 982

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
5100.14	O-Ring	O-20x2.5
5100.15	Curved tube	12 557 961
5200	Reticle unit	12 557 836
5200.1	Screw ring	12 557 995
5200.2	Front ring	12 557 974
5200.3	Flat spring	12 558 000
5210	Reticle assembled	12 557 838
5211	Reticle complete	12 557 839
5212	Reticle framed	12 557 840
5212.1	Field lens	12 557 849
5212.1-1	Pressed part for field lens	12 558 012
5212.2	Reticle	12 557 960
5212.2-1	Reticle	12 557 957
5212.3	Frame	12 557 976
5213	Traser-light framed	12 577 842
5213.1	Traser-light	12 557 981
5213.2	Frame	12 557 975
5214	Spring tube, complete	12 557 841
5214.1	Disk	12 557 994
5214.2	Spring tube	12 557 991
5200.4	Sphere	DIN 5401-2.5
5200.5	Adjusting ring	12 557 987
5200.6	Ring	12 558 006
5220	Field lens framed	12 557 837
5221	Field lens	12 557 849
5221.1	Pressed part for field lens	12 558 012
5220.1	Frame	12 557 983
5300	Objective, complete	12 557 843
5310	Cover glass framed	12 557 844
5311	Cover glass	12 557 955
5311.1	Pressed part for cover glass	12 558 018
5310.1	Screw ring	12 557 973
5301	Annular spring, complete	12 558 033
5301.1	Screw ring	12 558 035
5301.2	Annular spring	12 558 034
5300.1	Front ring	12 557 974
5300.2	Ring	12 557 984
5300.3	Crossed ring	12 557 980
5300.3	Frame	12 577 979

# HK-ACR PART REFERENCE NUMBERS

Reference No.	Item description	Part No.
5320	Objective framed	12 557 845
5321	Objective 10/35	12 557 846
5321.1	Objective lens kron	12 557 847
5321.1-1	Objective lens flint	12 557 848
5321.2-1	Pressed part for lens flint	12 558 011
5320.1	Frame	12 557 978
5300.5	Sphere	DIN 5401-2
5300.6	Sphere	DIN 5401-2.5
5300.7	O-Ring	O-23x1.5
5300.8	Screwed ring	DIN 553 M2x2.5
5300.9	Frame	12 557 996
5300.10	Adjusting ring	12 557 990
5300.11	Sealing Turcon Variscal	S 55606-0234-109 S
5300.12	Adjusting ring	12 557 989
5300.13	O-Ring	O-21x1.5
5300.14	Eccentric ring	12 557 986
5300.15	Eccentric ring	12 557 985
5300.16	Bearing tube	12 557 992
5300.17	O-Ring	O-16.5x1.5
6000	Carrying sling	12 557 620
6000.1	Buckle	12 557 619
6000.2	Sling	12 557 618